

REMARKS

I. Status of Claims

Claims 45-88 are currently pending. Without prejudice or disclaimer, claim 88 has been amended. Section 112 support for the amendment may be found, for example, on page 16, line 29 to page 17, line 7. Thus, no new matter has been added.

Applicants thank the Office for withdrawing the objection to claim 67.

II. Rejection under 35 U.S.C. § 112, ¶ 2

The Office maintains the rejection of claim 88 under 35 U.S.C. § 112, ¶ 2, as allegedly being indefinite. See Office Action at 2 and 5. Specifically, the Office questions what encompasses “industrial, sport or safety surfaces,” and “sound barriers . . . automotive locary; pipe or hose materials; roofing materials; and geomembranes” allegedly “fail to explicitly show where or to what extent the composition is a part of/or is that product.” *Id.* The Office also questions what is meant by “surfaces.” *Id.* The Office also asserts that “the recitation may have unobvious meanings, such as a sport surface could be a grass ball field, a ball bat, a ball, a ball glove. *Id.* The Office also requires Applicant to the remove of the word “locary” or to provide a dictionary citation. *Id.*

Applicants respectfully traverse for the following reasons.

To advance the prosecution, Applicants have amended claim 88 to remove recitation to “automotive locary” and add “wheel arch liner.” Upon further investigation, the reference to “locary” is due to an inadvertent failure to translate a term. As can be seen by the attached Italian and English versions of the same webpage, “locary” means

wheel arch liner. www.sanvaleriano.it (English and Italian versions attached hereto).

Accordingly, we believe no new matter is added by this correction. Applicants have also amended claim 88 to remove recitation to "industrial, sport or safety surfaces" and add "flooring for recreational areas." Thus, claim 88 merely recites specific classes of manufactured products comprising a thermoplastic material according to claim 45. It is submitted that, as amended, there cannot be confusion regarding the metes and bounds of a claim that identifies classes of materials that commonly comprise elastomeric materials.

It is also irrelevant what portion and to what extent the product comprises the claimed material, so long as it does comprise the claimed material. As M.P.E.P § 2173.04 explains:

Breadth of a claim is not to be equated with indefiniteness. *In re Miller*, 441 F.2d 689, 169 USPQ 597 (CCPA 1971). If the scope of the subject matter embraced by the claims is clear, and if applicants have not otherwise indicated that they intend the invention to be of a scope different from that defined in the claims, then the claims comply with 35 U.S.C. 112, second paragraph.

Accordingly, Applicants respectfully submit that the rejection is moot in light of the amendments and should be withdrawn.

III. Rejection under 35 U.S.C. § 102

The Office maintains the rejection of claims 45-48, 58-60, 64-66, 70-78, 87, and 88 under 35 U.S.C. § 102(e) as allegedly anticipated by U.S. Patent No. 6,476,117 to Wang et al. ("Wang"). See Office Action at 3.

Applicants respectfully traverse the rejection for the following reasons.

In order for Wang to anticipate the claimed invention, each and every element as set forth in the claim must be found, either expressly or inherently, in Wang. See M.P.E.P. § 2131.

Under the M.P.E.P. and the relevant case law, Wang does not anticipate the claimed invention. Specifically, the claimed invention recites (emphasis added):

A thermoplastic material comprising

(a) 5% by weight to 95% by weight of a vulcanized rubber in a subdivided form;

(b) 5% by weight to 95% by weight of at least one heterophase copolymer comprising a thermoplastic phase made from a propylene homopolymer or copolymer and an elastomeric phase made from a copolymer of ethylene with an α -olefin; and

(c) 0% by weight to 90% by weight of at least one α -olefin homopolymer or copolymer different from (b);

the amounts of (a), (b) and (c) being expressed with respect to the total weight of (a) + (b) + (c).

The Office asserts that Wang teaches, “20 to about 99% by weight heterophase copolymer.” See Office Action at 3.

Applicant maintains that Wang does not teach a heterophase copolymer. In fact the word “heterophase” copolymer is not in Wang.

In response to Applicant’s April 6, 2009 Response, the Office has made two arguments. First, the Office has incorrectly argued that “the instant claims do not exclude the concept of Wang et al at column 2 (lines 24-29) since the term “multiblock “ is deemed to embrace a diblock polymer.” Office Action at 5. In fact, the polymers of Wang can not be diblock polymer or a sequential polymer.

In the specification, Wang discloses a “multiblock” polymer but also discloses that the its invention requires “at least one soft...polymeric segment and at least two hard...polyalkylene segments.” Wang at col. 2, ll. 24-30 and col. 3, ll. 1-6. This passage illustrates that Wang can not encompass a “diblock” copolymer but at a minimum encompasses a “triblock” copolymer. One of skill in the art would recognize that there is a clear distinction between diblock, triblock, terblock, graft, blockgraft, multiblock, and random, which can even be seen in graphical representations in F. Calleja and Z. Roslaniec, Block Copolymers, p. 283 (2000) (attached hereto). In addition, column 2, lines 24-30 illustrates that the blocks in Wang are arranged without order or randomly. In contrast, the present invention is a “sequential copolymerization.” Applicant’s specification at pg. 6, ll. 1-16. Therefore, Wang differs from the invention in that it can not be a diblock copolymer nor can it be a sequential copolymer.

Second, the Office argues that the “manner of production does not provide weight in the patentability of the claims since the products are deemed to be identical.” *Id.* at 5-6. Process limitations, however, cannot to be ignored if they yield a structural difference as the M.P.E.P. § 2113 has explained:

The structure implied by the process steps should be considered when assessing the patentability of product-by-process claims over the prior art, especially where the product can only be defined by the process steps by which the product is made, or where the manufacturing process steps would be expected to impart distinctive structural characteristics to the final product. See, e.g., *In re Garnero*, 412 F.2d 276, 279, 162 USPQ 221, 223 (CCPA 1979) (holding “interbonded by interfusion” to limit structure of the claimed composite and noting that terms such as “welded,” “intermixed,” “ground in place,” “press fitted,” and “etched” are capable of construction as structural limitations.)

As discussed below, being a heterophase copolymer implies a structure that exclude the copolymers of Wang.

One of skill in the art would recognize that a heterophase polymer is formed by sequential copolymerization which is a specific type of polymerization. Applicant's Specification at pg. 6, ll. 1-16.

One of skill in the art would also recognize that different methods of polymerizations can result in structurally different having different molecular weights, molecular weight distributions, crystallinity, branching, and repeat units. George Odian, Principles of Polymerization, 1-9 and 17-36 (2004) (attached hereto). The different polymers would then have different applications and mechanical properties due to the different characteristics. *Id.*

A common sequential polymerization technique for making a heterophase copolymer is referred to as Catalloy technology. An example of this technology can be found in U.S. Patent No. 5,286,564 at col. 3, ll. 6-12 and col. 6, ll. 65 to col. 7, ll. 43. The present specification discloses the sequential copolymerization first of propylene and then a mixture of ethylene with an α -olefin, like propylene, which is consistent with the Catalloy technique. Applicant's Specification at pg. 6, ll. 1-16. In the Catalloy technology, an amorphous/elastomeric ethylene-propylene copolymer is molecularly dispersed in a predominately semicrystalline/thermoplastic propylene-ethylene copolymer. The technique employs a multistep reactor and the polymerization of different monomers is done sequentially, resulting in an intimate mixture of the phases of the heterophase copolymer but *not a chemical link*. The lack of a chemical link demonstrates another way the copolymer of claim 45 is structurally different from Wang.

As stated in Wang, the polymers are synthesized using condensation polymerization. Wang at col. 7, lines 56-60 and Example 1. One of skill in the art would know that condensation is defined in chemistry as "a chemical reaction involving union between molecules often with elimination of a simple molecule (as water) to form a new more complex compound of often greater molecular weight." Webster's Ninth New Collegiate Dictionary, 273 (9th 1990). Condensation polymerization could not produce a polymer that falls within the definition of heterophase copolymer. The polymerization in Wang contains a chemical link in contrast to the heterophase copolymer which is lacking in a chemical link..

Furthermore, as noted by the Examiner, Wang describes its polymers as "multi-block" (really tri-block or greater) polymers. Wang at col. 2, lines 24-30, col. 3, lines 1-6. A block polymer is a polymer molecule with alternating sections of one chemical composition separated by sections of a different chemical composition. Hawley's Condensed Chemical Dictionary, 151 (13th ed. 1997). Thus, as a block polymer, Wang does not have separate physical phases that can be thermoplastic phase and elastomeric phase, as claimed. At best, each polymer molecule of Wang has sections that are thermoplastic or elastomeric in nature. Therefore, Wang does not contain a heterophase polymer as in claim 45 of the present disclosure and the polymers are not identical as claimed by the Office.

Since Wang does not contain a heterophase polymer, it does not anticipate because it fails to teach or suggest every limitation of the claimed invention. Thus, Applicants respectfully submit that the rejection should be withdrawn.

IV. Rejections under 35 U.S.C. § 103

A. The Examiner rejects claims 45-53, 58-60, 64-78, 87, and 88 under 35 U.S.C. § 102(e) as anticipated by, or, in the alternative, under 35 U.S.C. § 103 as allegedly being unpatentable over Wang. See Office Action at 3-4.

Applicants respectfully traverse for the following reasons.

As discussed above, Wang fails to anticipate the claimed invention because it fails to teach each and every limitation of the claimed invention. For this reason, Wang cannot anticipate claims 45-53, 58-60, 64-78, 87, and 88.

With respect to obviousness, the Examiner bears the initial burden of factually supporting any *prima facie* conclusion of obviousness. See M.P.E.P. § 2142. In *KSR Int'l Co. v. Teleflex Inc.*, 82 U.S.P.Q.2d 1385 (2007), the Supreme Court confirmed that the “framework for applying the statutory language of §103” is still based on its landmark decision in *Graham v. John Deere Co. of Kansas City*, 148 U.S.P.Q. 459 (1966). Under *Graham*, four factors must be considered when determining whether an invention is obvious: (1) the scope and content of the prior art; (2) the differences between the prior art and the claims at issue; (3) the level of ordinary skill in the art; and (4) secondary considerations. 148 U.S.P.Q. at 467. The obviousness or non-obviousness of the claimed invention is then evaluated in view of the results of these inquiries. See *Graham*, 148 U.S.P.Q. 467; see also *KSR*, 82 U.S.P.Q. 2d at 1388. Implicit in this analysis is the requirement that the Office show that each and every element of the rejected claims is disclosed in the prior art. M.P.E.P. § 2143.03.

In the instant case, the Examiner has not established a prima facie case of obviousness, at least because Wang does not teach or suggest a process having each and every element of the pending claims.

Further, there would be no motivation or reasonable expectation of success from modifying the product of Wang. Wang is directed towards damping which is defined as "the absorption of mechanical energy, such as vibrational or sound energy." Wang at col. 1, ll.17-18. Wang's invention and its advantages derive from the polymer having these "hard" and "soft" segments. Nothing in Wang teaches or suggests such an advantage would be or could be maintained by using a heterophase polymer. In fact, as discussed above, different polymerization techniques can result in very different polymers. The different polymers may not have the desired properties. Thus one of skill in the art would not be motivated to modify Wang because there would be a reasonable expectation of failure to such a modification.. M.P.E.P. § 2143.01(V) ("If proposed modification would render the prior art invention being modified unsatisfactory for its intended purpose, then there is no suggestion or motivation to make the proposed modification.").

For this reason, Applicants respectfully submit that the rejection is improper and should be withdrawn.

B. The Examiner rejects claims 45-88 under 35 U.S.C. § 103 as allegedly being unpatentable over Wang in view of U.S. Patent No. 4,818,785 to Ottawa et al. ("Ottawa"). See Office Action at 4. The Examiner even concedes that Wang "is silent as to the specific rubber employed as the cryogenically ground rubber or the inclusion of a

second thermoplastic resin (c).” *See id.* However, the Examiner argues that Ottawa allegedly cures these deficiencies. *See id.*

Applicants respectfully traverse for the following reasons.

First, for the reasons provided above, Applicants submit that Wang does not teach all that the Examiner believes it does and a person of ordinary skill in the art would not be motivated to modify Wang and would not have a reasonable expectation of success from such a modification.

Similarly, Applicants submit that one skilled in the art would not be motivated to modify Wang to encompass the polymer of Ottawa. As discussed above, Wang’s invention is based on the structure of the polymer. Nothing in Ottawa or Wang suggests that their respective polymers are interchangeable. M.P.E.P. § 2143.01(V).

For these reasons, Applicants respectfully submit that the rejection should be withdrawn.

CONCLUSION

In view of the foregoing amendments and remarks, Applicants respectfully request reconsideration of this application and the timely allowance of the pending claims.

If the Examiner believes a telephone conference could be useful in resolving any outstanding issues, he is respectfully invited to contact Applicant’s undersigned counsel at (202) 408-4275.

Please grant any extensions of time required to enter this response and charge any additional required fees to our Deposit Account No. 06-0916.

Respectfully submitted,

FINNEGAN, HENDERSON, FARABOW,
GARRETT & DUNNER, L.L.P.

Dated: August 21, 2009

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Attachments:

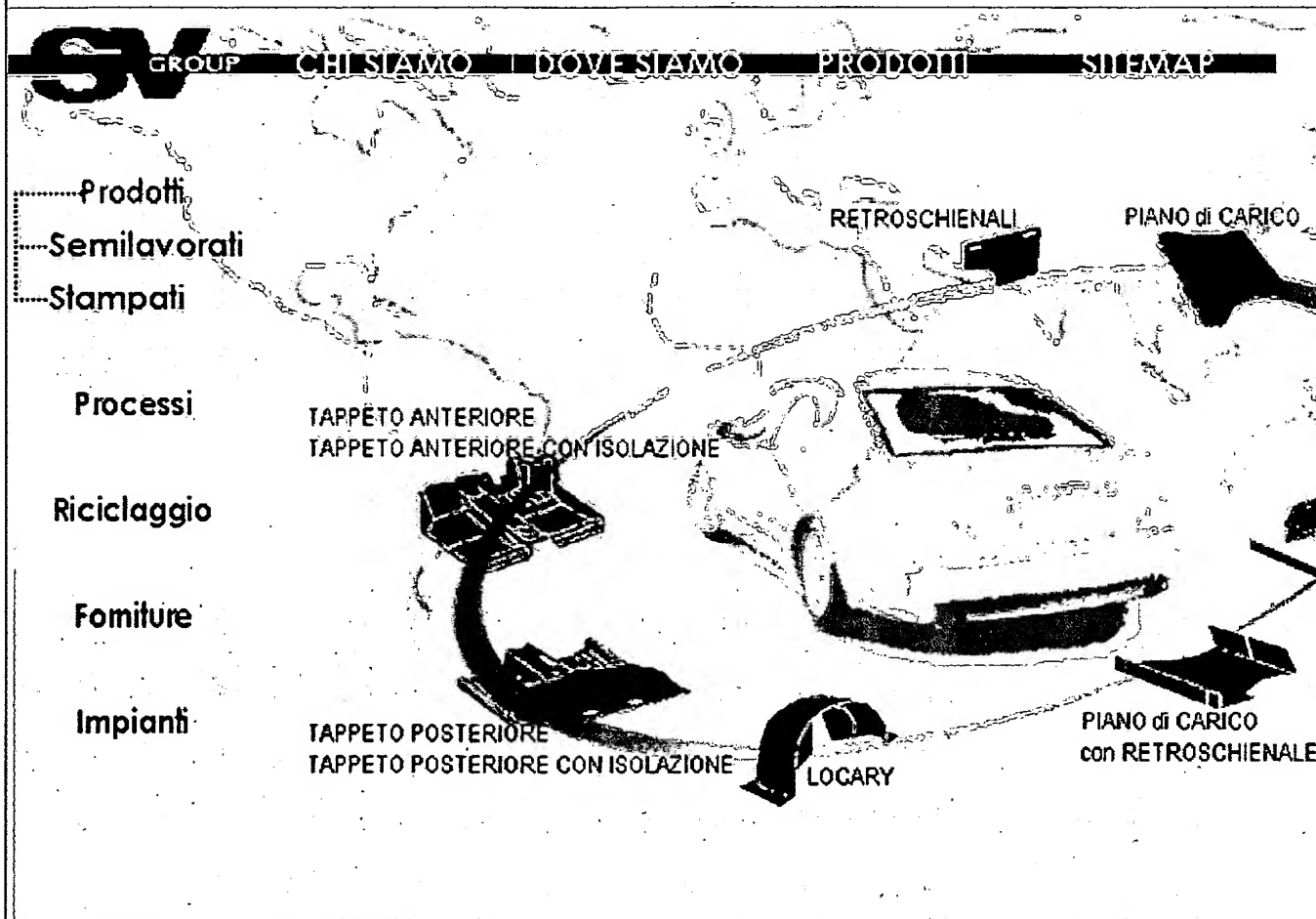
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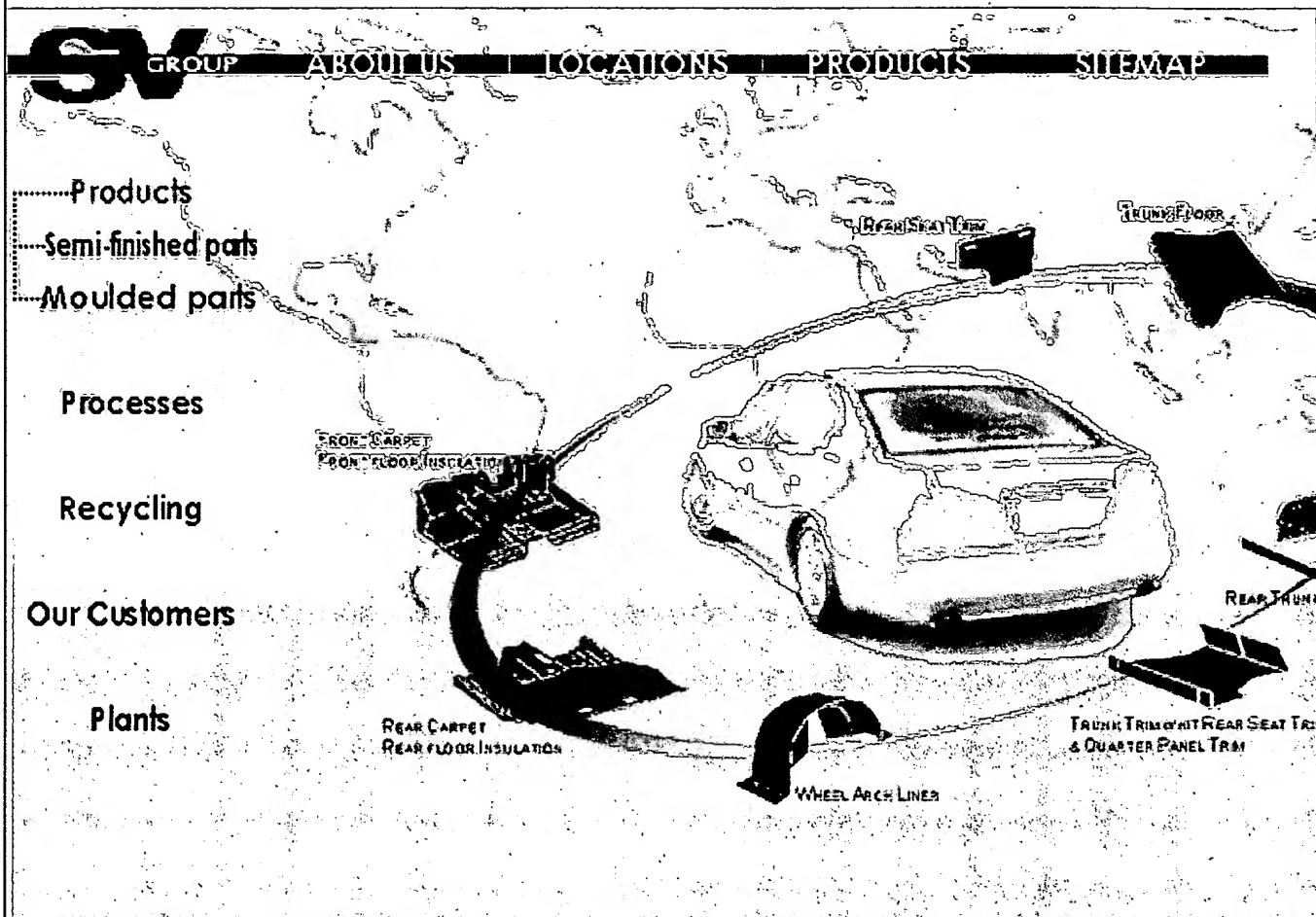
F. Calleja and Z. Roslaniec, Block Copolymers, p. 283 (2000)

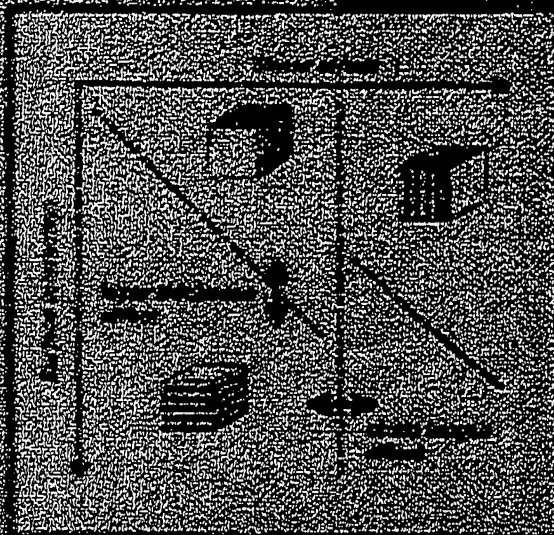
George Odian, Principles of Polymerization, 1-9 and 17-36 (2004)

Webster's Ninth New Collegiate Dictionary, 273 (9th 1990)

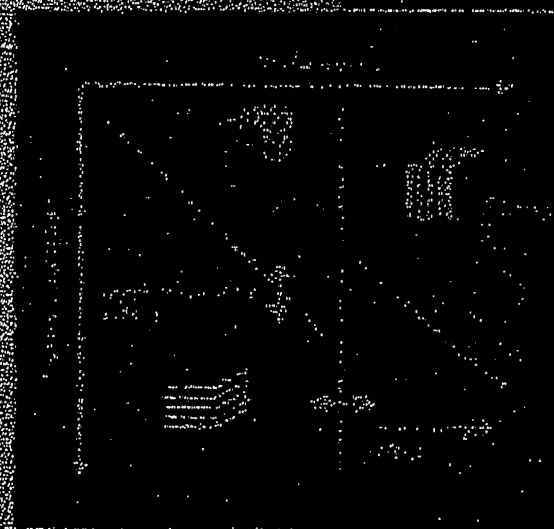
Hawley's Condensed Chemical Dictionary, 151 (13th ed. 1997)







Block Copolymers



Francisco J. Baltá Calleja
Zbigniew Roslaniec

Before these topics are addressed, it is necessary to define the *class of block copolymers*. Symmetric diblock copolymers with long blocks such as indicated in Fig. 1 are excellent representatives of this class. But (a) diblock copolymers with two short blocks or with one long and one short block, (b) triblock, (c) multiblock, and (d) graft copolymers have a blocky architecture, too, as have terblock and blockgraft copolymers, which consist of three monomer units (Fig. 2). It is thus hard to distinguish the block copolymers from the others.

But a copolymer demonstrates its blockiness definitely when its blocks segregate from one another. In the context of this chapter, therefore, one can define *good block copolymers for blends* as follows: They must be able to behave as in Fig. 1, proving their blockiness by segregating in the interfaces of blends. Using this definition, all copolymers in Fig. 2 but the multiblock and the random copolymers can be block copolymers. Theoreticians prefer to deal with diblock copolymers, but triblock and graft copolymers are, in fact, much more important in industry (20). Graft copolymers $\alpha g \beta$ may have the biggest potential.

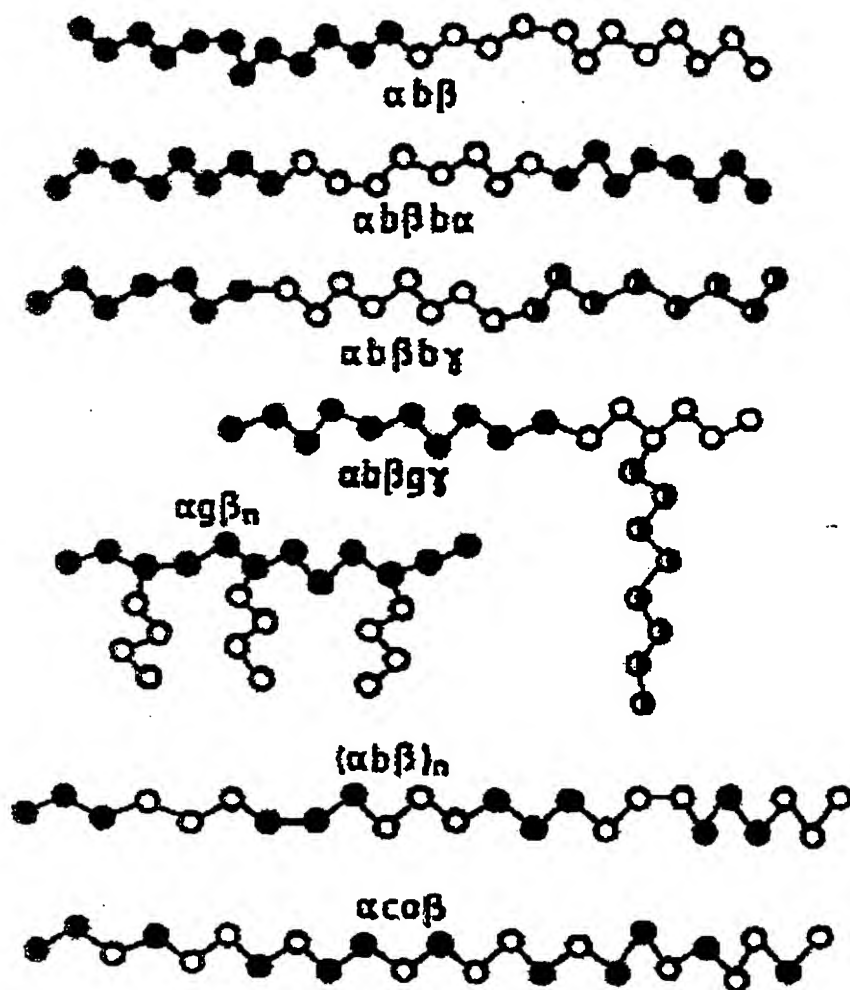


Fig. 2 Types of copolymers: diblock ($\alpha\beta$), triblock ($\alpha\beta\beta\alpha$), terblock ($\alpha\beta\beta\gamma$), graft ($\alpha g \beta_n$), blockgraft ($\alpha\beta g \gamma$), multiblock ($(\alpha\beta\beta)_n$), random ($\alpha c \circ \beta$).

PRINCIPLES OF POLYMERIZATION

Fourth Edition

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City University of New York
Staten Island, New York



**WILEY-
INTERSCIENCE**

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his new edition. I am especially Stephen A. Miller who graciously xt. Their suggestions for improve- many colleagues who generously cs: Helmut G. Alt, Jose M. Asua, gi Cavallo, John Chadwick, Geoff ngham, Thomas P. Davis, Pieter J. , Robert Gilbert, Alexei Gridnev, k, Jorge Herrera-Ordonez, Walter lav Kahovec, Mikiharu Kamachi, Olayo, Patrick Lacroix-Desmazes, , Stanislaw Penczek, Peter Plesch, gi Resconi, Ezio Rizzardo, Greg a, Brigitte Voit, Kenneth Wagener, rid G. Westmoreland, Edward S. da, and Adolfo Zambelli. Their he text.

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GEORGE ODIAN

CHAPTER 1

INTRODUCTION

Polymers are macromolecules built up by the linking together of large numbers of much smaller molecules. The small molecules that combine with each other to form polymer molecules are termed *monomers*, and the reactions by which they combine are termed *polymerizations*. There may be hundreds, thousands, tens of thousands, or more monomer molecules linked together in a polymer molecule. When one speaks of polymers, one is concerned with materials whose molecular weights may reach into the hundreds of thousands or millions.

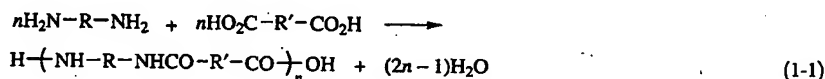
1-1 TYPES OF POLYMERS AND POLYMERIZATIONS

There has been and still is considerable confusion concerning the classification of polymers. This is especially the case for the beginning student who must appreciate that there is no single generally accepted classification that is unambiguous. During the development of polymer science, two types of classifications have come into use. One classification is based on polymer structure and divides polymers into *condensation* and *addition* polymers. The other classification is based on polymerization mechanism and divides polymerizations into *step* and *chain* polymerizations. Confusion arises because the two classifications are often used interchangeably without careful thought. The terms *condensation* and *step* are often used synonymously, as are the terms *addition* and *chain*. Although these terms may often be used synonymously because most condensation polymers are produced by step polymerizations and most addition polymers are produced by chain polymerizations, this is not always the case. The condensation-addition classification is based on the composition or structure of polymers. The step-chain classification is based on the mechanisms of the polymerization processes.

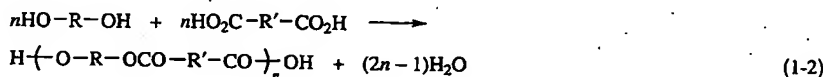
2 INTRODUCTION

1-1a Polymer Composition and Structure

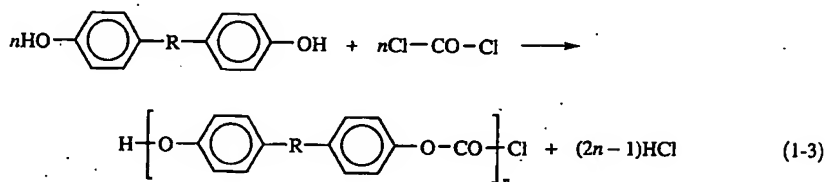
Polymers were originally classified by Carothers [1929] into condensation and addition polymers on the basis of the compositional difference between the polymer and the monomer(s) from which it was synthesized. Condensation polymers were those polymers that were formed from polyfunctional monomers by the various condensation reactions of organic chemistry with the elimination of some small molecule such as water. An example of such a condensation polymer is the polyamides formed from diamines and diacids with the elimination of water according to



where R and R' are aliphatic or aromatic groupings. The unit in parentheses in the polyamide formula repeats itself many times in the polymer chain and is termed the *repeating unit*. The elemental composition of the repeating unit differs from that of the two monomers by the elements of water. The polyamide synthesized from hexamethylene diamine, $\text{R} = (\text{CH}_2)_6$, and adipic acid, $\text{R}' = (\text{CH}_2)_4$, is the extensively used fiber and plastic known commonly as nylon 6/6 or poly(hexamethylene adipamide). Other examples of condensation polymers are the polyesters formed from diacids and diols with the elimination of water and the



polycarbonates from the reaction of an aromatic dihydroxy reactant and phosgene with the elimination of hydrogen chloride:



The common condensation polymers and the reactions by which they are formed are shown in Table 1-1. It should be noted from Table 1-1 that for many of the condensation polymers there are different combinations of reactants that can be employed for their synthesis. Thus polyamides can be synthesized by the reactions of diamines with diacids or diacyl chlorides and by the self-condensation of amino acids. Similarly, polyesters can be synthesized from diols by esterification with diacids or ester interchange with diesters.

Some naturally occurring polymers such as cellulose, starch, wool, and silk are classified as condensation polymers, since one can postulate their synthesis from certain hypothetical reactants by the elimination of water. Thus cellulose can be thought of as the polyether formed by the dehydration of glucose. Carothers included such polymers by defining condensation polymers as those in which the formula of the repeating unit lacks certain atoms that are present in the monomer(s) from which it is formed or to which it may be degraded. In this

TABLE 1-1 Typical Condensation Polymers

Type	Characteristic Linkage	Polymerization Reaction
Polyamide	-NH-CO-	$\text{H}_2\text{N}-\text{R}-\text{NH}_2 + \text{HO}_2\text{C}-\text{R}'-\text{CO}_2\text{H} \longrightarrow \text{H}-(\text{NH}-\text{R}-\text{NHCO}-\text{R}'-\text{CO})_n\text{OH} + \text{H}_2\text{O}$ $\text{H}_2\text{N}-\text{R}-\text{NH}_2 + \text{ClCO}-\text{R}'-\text{COCl} \longrightarrow \text{H}-(\text{NH}-\text{R}-\text{NHCO}-\text{R}'-\text{CO})_n\text{Cl} + \text{HCl}$ $\text{H}_2\text{N}-\text{R}-\text{CO}_2\text{H} \longrightarrow \text{H}-(\text{NH}-\text{R}-\text{CO})_n\text{OH} + \text{H}_2\text{O}$
Protein, wool, silk	-NH-CO-	Naturally occurring polypeptide polymers; degradable to mixtures of different amino acids. $\text{H}-(\text{NH}-\text{R}-\text{CONH}-\text{R}'-\text{CO})_n\text{OH} + \text{H}_2\text{O} \longrightarrow \text{H}_2\text{N}-\text{R}-\text{CO}_2\text{H} + \text{H}_2\text{N}-\text{R}'-\text{CO}_2\text{H}$
Polyester	-CO-O-	$\text{HO}-\text{R}-\text{OH} + \text{HO}_2\text{C}-\text{R}'-\text{CO}_2\text{H} \longrightarrow \text{H}-(\text{O}-\text{R}-\text{OCO}-\text{R}'-\text{CO})_n\text{OH} + \text{H}_2\text{O}$

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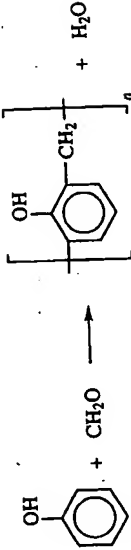
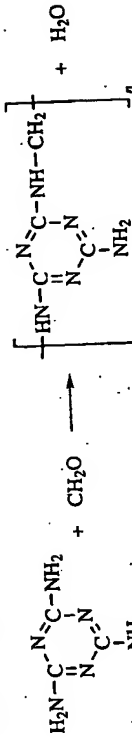
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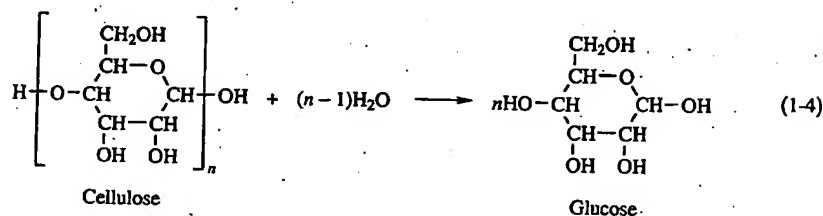
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TABLE 1-1 Typical Condensation Polymers

Type	Characteristic Linkage	Polymerization Reaction
Polyamide	$-NH-CO-$	$H_2N-R-NH_2 + HO_2C-R'-CO_2H \longrightarrow H-(NH-R-NHCO-R'-CO)_n-OH + H_2O$ $H_2N-R-NH_2 + ClCO-R'-COCl \longrightarrow H-(NH-R-NHCO-R'-CO)_n-Cl + HCl$ $H_2N-R-CO_2H \longrightarrow H-(NH-R-CO)_n-OH + H_2O$
Protein, wool, silk	$-NH-CO-$	Naturally occurring polypeptide polymers; degradable to mixtures of different amino acids.
Polyester	$-CO-O-$	$H-(NH-R-CONH-R'-CO)_n-OH + H_2O \longrightarrow H_2N-R-CO_2H + H_2N-R'-CO_2H$ $HO-R-OH + HO_2C-R'-CO_2H \longrightarrow H-O-R-OCO-R'-CO)_n-OH + H_2O$ $HO-R-OH + R'O_2C-R'-CO_2R'' \longrightarrow H-O-R-OCO-R'-CO)_n-OH + R''OH$ $HO-R-CO_2H \longrightarrow H-(O-R-CO)_n-OH + H_2O$
Polyurethane	$-O-CO-NH-$	$HO-R-OH + OCN-R'-NCO \longrightarrow H-(O-R-OCO-NH-R'-NH-CO)_n-$
Polysiloxane	$-Si-O-$	$HO-R-OH + H_2O \longrightarrow H-(O-R-SiR_2)_n-OH + H_2O$ $Cl-SiR_2-Cl \xrightarrow{H_2O} HO-SiR_2-OH \xrightarrow{-HCl} H-(O-SiR_2)_n-OH + H_2O$
Phenol-formaldehyde	$-Ar-CH_2-$	
Urea-formaldehyde	$-NH-CH_2-$	$H_2N-CO-NH_2 + CH_2O \longrightarrow H_2N-CO-NH-CH_2)_n + H_2O$
Melamine-formaldehyde	$-NH-CH_2-$	
Polysulfide	$-S_m-$	$Cl-R-Cl + Na_2S_m \longrightarrow (S_m-R)_n + NaCl$
Polyacetal	$-O-CH(R)-O-$	$R-CHO + HO-R'-OH \longrightarrow (O-R'-OCHR)_n + H_2O$

4 INTRODUCTION

sense cellulose is considered a condensation polymer, since its hydrolysis yields glucose, which contains the repeating unit of cellulose plus the elements of water

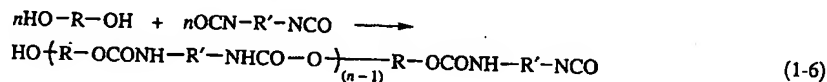


Addition polymers were classified by Carothers as those formed from monomers without the loss of a small molecule. Unlike condensation polymers, the repeating unit of an addition polymer has the same composition as the monomer. The major addition polymers are those formed by polymerization of monomers containing the carbon-carbon double bond. Such monomers will be referred to as *vinyl monomers* throughout this text. (The term *vinyl*, strictly speaking, refers to a $\text{CH}_2=\text{CH}-$ group attached to some substituent. Our use of the term *vinyl monomer* is broader—it applies to all monomers containing a carbon-carbon double bond, including monomers such as methyl methacrylate, vinylidene chloride, and 2-butene as well as vinyl chloride and styrene. The term *substituted ethylenes* will also be used interchangeably with the term vinyl monomers.) Vinyl monomers can be made to react with themselves to form polymers by conversion of their double bonds into saturated linkages, for example



where Y can be any substituent group such as hydrogen, alkyl, aryl, nitrile, ester, acid, ketone, ether, and halogen. Table 1-2 shows many of the common addition polymers and the monomers from which they are produced.

The development of polymer science with the study of new polymerization processes and polymers showed that the original classification by Carothers was not entirely adequate and left much to be desired. Thus, for example, consider the polyurethanes, which are formed by the reaction of diols with diisocyanates without the elimination of any small molecule:



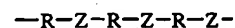
Using Carothers' original classification, one would classify the polyurethanes as addition polymers, since the polymer has the same elemental composition as the sum of the monomers. However, the polyurethanes are structurally much more similar to the condensation polymers than to the addition polymers. The urethane linkage ($-\text{NH}-\text{CO}-\text{O}-$) has much in common with the ester ($-\text{CO}-\text{O}-$) and amide ($-\text{NH}-\text{CO}-$) linkages.

To avoid the obviously incorrect classification of polyurethanes as well as of some other polymers as addition polymers, polymers have also been classified from a consideration of the chemical structure of the groups present in the polymer chains. Condensation polymers have been defined as those polymers whose repeating units are joined together by functional

TABLE 1-2 Typical Addition

Polymer
Polyethylene
Polyisobutylene
Polyacrylonitrile
Poly(vinyl chloride)
Polystyrene
Poly(methyl methacrylate)
Poly(vinyl acetate)
Poly(vinylidene chloride)
Polytetrafluoroethylene
Polyisoprene (natural rubber)

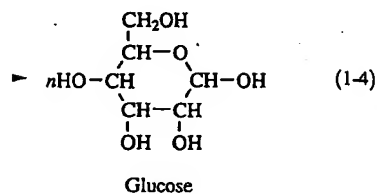
units of one kind or another
Thus the structure of conden



I

where R is an aliphatic or a
-NHCO-, -S-, -OCONH
other hand, do not contain st
may, however, be present in
mer chain. According to this
classified as condensation p

er, since its hydrolysis yields glucose, the elements of water



s those formed from monomers without polymers, the repeating unit of an addition polymer. The major addition polymers are those the carbon-carbon double bond. Such throughout this text. (The term *vinyl*, strictly some substituent. Our use of the term polymers containing a carbon-carbon double bond, vinylidene chloride, and 2-butene substituted ethylenes will also be used interchangeably. monomers can be made to react with double bonds into saturated linkages,

(1-5)

hydrogen, alkyl, aryl, nitrile, ester, acid, and the common addition polymers and

many of new polymerization processes and methods was not entirely adequate and the polyurethanes, which are formed by the elimination of any small molecule:



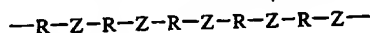
to classify the polyurethanes as addition polymers as the sum of the monomers is much more similar to the condensation polymer linkage ($-\text{NH}-\text{CO}-\text{O}-$) has much more $-\text{NH}-\text{CO}-$ linkages.

polyurethanes as well as of some other polymers have been classified from a consideration of polymer chains. Condensation polymers units are joined together by functional

TABLE 1-2 Typical Addition Polymers

Polymer	Monomer	Repeating Unit
Polyethylene	$\text{CH}_2=\text{CH}_2$	$-\text{CH}_2-\text{CH}_2-$
Polyisobutylene	$\begin{array}{c} \text{CH}_3 \\ \\ \text{CH}_2=\text{C} \\ \\ \text{CH}_3 \end{array}$	$\begin{array}{c} \text{CH}_3 \\ \\ -\text{CH}_2-\text{C}- \\ \\ \text{CH}_3 \end{array}$
Polyacrylonitrile	$\text{CH}_2=\text{CH}-\text{CN}$	$\begin{array}{c} -\text{CH}_2-\text{CH}- \\ \\ \text{CN} \end{array}$
Poly(vinyl chloride)	$\text{CH}_2=\text{CH}-\text{Cl}$	$\begin{array}{c} -\text{CH}_2-\text{CH}- \\ \\ \text{Cl} \end{array}$
Polystyrene	$\text{CH}_2=\text{CH}-\phi$	$\begin{array}{c} -\text{CH}_2-\text{CH}- \\ \\ \phi \end{array}$
Poly(methyl methacrylate)	$\begin{array}{c} \text{CH}_3 \\ \\ \text{CH}_2=\text{C} \\ \\ \text{CO}_2\text{CH}_3 \end{array}$	$\begin{array}{c} \text{CH}_3 \\ \\ -\text{CH}_2-\text{C}- \\ \\ \text{CO}_2\text{CH}_3 \end{array}$
Poly(vinyl acetate)	$\text{CH}_2=\text{CH}-\text{OCOCH}_3$	$\begin{array}{c} -\text{CH}_2-\text{CH}- \\ \\ \text{OCOCH}_3 \end{array}$
Poly(vinylidene chloride)	$\begin{array}{c} \text{Cl} \\ \\ \text{CH}_2=\text{C} \\ \\ \text{Cl} \end{array}$	$\begin{array}{c} \text{Cl} \\ \\ -\text{CH}_2-\text{C}- \\ \\ \text{Cl} \end{array}$
Polytetrafluoroethylene	$\begin{array}{c} \text{F} \quad \text{F} \\ \quad \\ \text{C}=\text{C} \\ \quad \\ \text{F} \quad \text{F} \end{array}$	$\begin{array}{c} \text{F} \quad \text{F} \\ \quad \\ -\text{C}-\text{C}- \\ \quad \\ \text{F} \quad \text{F} \end{array}$
Polyisoprene (natural rubber)	$\begin{array}{c} \text{CH}_2=\text{C}-\text{CH}=\text{CH}_2 \\ \\ \text{CH}_3 \end{array}$	$\begin{array}{c} -\text{CH}_2-\text{C}=\text{CH}-\text{CH}_2- \\ \\ \text{CH}_3 \end{array}$

units of one kind or another such as the ester, amide, urethane, sulfide, and ether linkages. Thus the structure of condensation polymers has been defined by

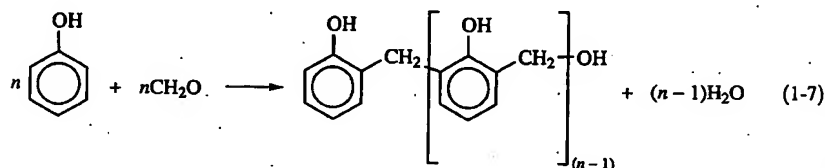


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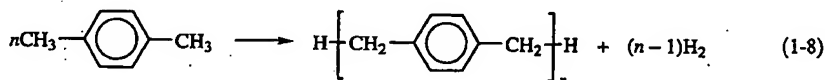
where R is an aliphatic or aromatic grouping and Z is a functional unit such as $-\text{OCO}-$, $-\text{NHCO}-$, $-\text{S}-$, $-\text{OCONH}-$, $-\text{O}-$, $-\text{OCOO}-$, and $-\text{SO}_2-$. Addition polymers, on the other hand, do not contain such functional groups as part of the polymer chain. Such groups may, however, be present in addition polymers as pendant substituents hanging off the polymer chain. According to this classification, the polyurethanes are readily and more correctly classified as condensation polymers.

6 INTRODUCTION

It should not be taken for granted that all polymers that are defined as condensation polymers by Carothers' classification will also be so defined by a consideration of the polymer chain structure. Some condensation polymers do not contain functional groups such as ester or amide in the polymer chain. An example is the phenol-formaldehyde polymers produced by the reaction of phenol (or substituted phenols) with formaldehyde



These polymers do not contain a functional group within the polymer chain but are classified as condensation polymers, since water is split out during the polymerization process. Another example is poly(*p*-xylene), which is produced by the oxidative coupling (dehydrogenation) of *p*-xylene:



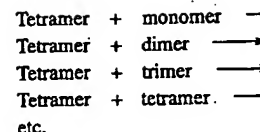
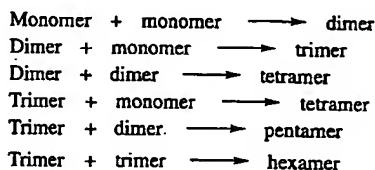
In summary, a polymer is classified as a condensation polymer if its synthesis involves the elimination of small molecules, or it contains functional groups as part of the polymer chain, or its repeating unit lacks certain atoms that are present in the (hypothetical) monomer to which it can be degraded. If a polymer does not fulfill any of these requirements, it is classified as an addition polymer.

1-1b Polymerization Mechanism

In addition to the structural and compositional differences between polymers, Flory [1953] stressed the very significant difference in the mechanism by which polymer molecules are built up. Although Flory continued to use the terms condensation and addition in his discussions of polymerization mechanism, the more recent terminology classifies polymerizations into step and chain polymerizations.

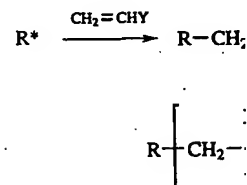
Chain and step polymerizations differ in several features, but the most important difference is in the identities of the species that can react with each other. Another difference is the manner in which polymer molecular size depends on the extent of conversion.

Step polymerizations proceed by the stepwise reaction between the functional groups of reactants as in reactions such as those described by Eqs. 1-1 through 1-3 and Eqs. 1-6 through 1-8. The size of the polymer molecules increases at a relatively slow pace in such polymerizations. One proceeds from monomer to dimer, trimer, tetramer, pentamer, and so on



until eventually large-sized polymerization that distinguishes between any of the different-sized species.

The situation is quite different when an initiator species R^* (radical, cation, or anion) produces the successive additions of large distinguishing characteristic monomer reacting only with the different-sized species such as other. By far the most common process can be depicted as:

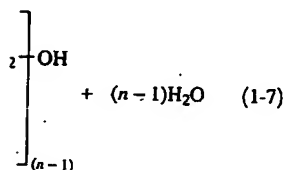


Each monomer molecule that grows proceeds by the successive addition of monomer molecules. The growth of the polymer is the sum of a number of

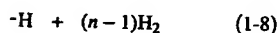
The typical step and chain polymerizations are distinguished by their relative rates of polymerization at any time after the start of the reaction. For the two polymerizations, 1% conversion, one will always observe the same rate of high-molecular-weight polymerization. The only chain polymerization is the continuous increase in the number of high-molecular-weight polymer molecules as the reaction proceeds (>98% conversion) are dependent on conversion.

The classification of polymerization by structure and composition, is linear increase of molecular

defined as condensation polymerization. The consideration of the polymer functional groups such as ester and aldehyde polymers produced aldehyde



polymer chain but are classified as condensation polymerization process. Another characteristic of condensation polymerization is coupling (dehydration)

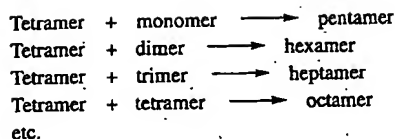


or if its synthesis involves the addition of monomer as part of the polymer chain, it is classified as addition polymerization. A hypothetical monomer to these requirements, it is classified as addition polymerization.

between polymers, Flory [1953] has shown that rich polymer molecules are produced by addition and addition in his discussion of polymerization. Flory classifies polymerizations

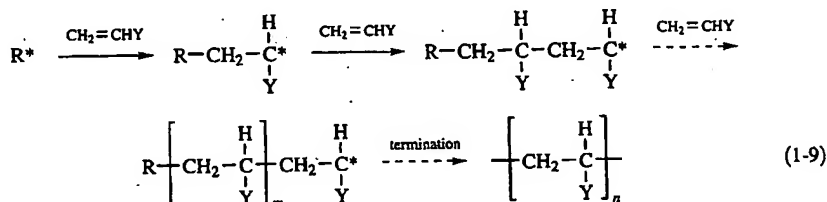
as the most important difference. Another difference is the rate of conversion.

in the functional groups of monomers. Eqs. 1-3 and Eqs. 1-6 through 1-9 show the slow pace in such polymerization, pentamer, and so on



until eventually large-sized polymer molecules have been formed. The characteristic of step polymerization that distinguishes it from chain polymerization is that reaction occurs between any of the different-sized species present in the reaction system.

The situation is quite different in chain polymerization where an initiator is used to produce an initiator species R^* with a reactive center. The reactive center may be either a free radical, cation, or anion. Polymerization occurs by the propagation of the reactive center by the successive additions of large numbers of monomer molecules in a chain reaction. The distinguishing characteristic of chain polymerization is that polymer growth takes place by monomer reacting only with the reactive center. Monomer does not react with monomer and the different-sized species such as dimer, trimer, tetramer, and n -mer do not react with each other. By far the most common example of chain polymerization is that of vinyl monomers. The process can be depicted as



Each monomer molecule that adds to a reactive center regenerates the reactive center. Polymer growth proceeds by the successive additions of hundreds or thousands or more monomer molecules. The growth of the polymer chain ceases when the reactive center is destroyed by one or more of a number of possible termination reactions.

The typical step and chain polymerizations differ significantly in the relationship between polymer molecular weight and the percent conversion of monomer. Thus if we start out step and chain polymerizations side by side, we may observe a variety of situations with regard to their relative rates of polymerization. However, the molecular weights of the polymers produced at any time after the start of the reactions will always be very characteristically different for the two polymerizations. If the two polymerizations are stopped at 0.1% conversion, 1% conversion, 10% conversion, 40% conversion, 90% conversion, and so on, one will always observe the same behavior. The chain polymerization will show the presence of high-molecular-weight polymer molecules at all percents of conversion. There are no intermediate-sized molecules in the reaction mixture—only monomer, high-polymer, and initiator species. The only change that occurs with conversion (i.e., reaction time) is the continuous increase in the number of polymer molecules (Fig. 1-1a). On the other hand, high-molecular-weight polymer is obtained in step polymerizations only near the very end of the reaction (>98% conversion) (Fig. 1-1b). Thus both polymer size and the amount of polymer are dependent on conversion in step polymerization.

The classification of polymers according to polymerization mechanism, like that by structure and composition, is not without its ambiguities. Certain polymerizations show a linear increase of molecular weight with conversion (Fig. 1-1c) when the polymerization

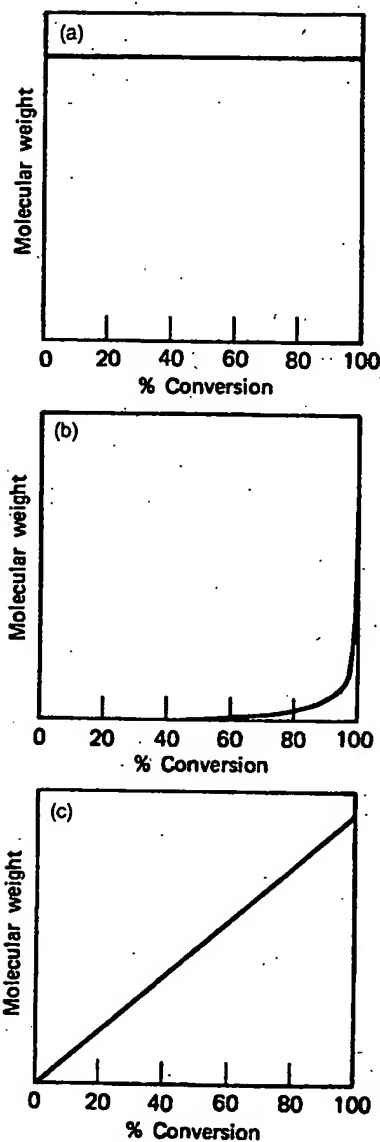
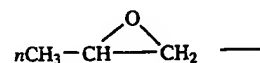


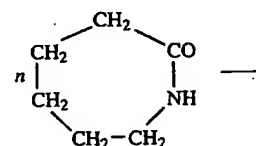
Fig. 1-1 Variation of molecular weight with conversion; (a) chain polymerization; (b) step polymerization; (c) nonterminating chain polymerization and protein synthesis.

mechanism departs from the normal chain pathway. This is observed in certain chain polymerizations, which involve a fast initiation process coupled with the absence of reactions that terminate the propagating reactive centers. Biological syntheses of proteins also show the behavior described by Fig. 1-1c because the various monomer molecules are directed to react in a very specific manner by an enzymatically controlled process.

The ring-opening polymerization



or ϵ -caprolactam



usually proceed by the chain mechanism, and molecular weight on conversion in these polymerizations often follows the step mechanism.

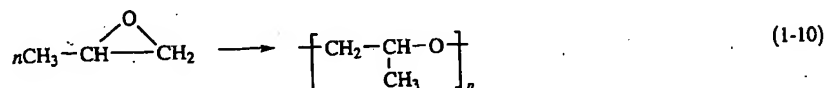
The International Union of Pure and Applied Chemistry (IUPAC) uses the term *polycondensation* instead of *step polymerization* for reactions in which small molecules are eliminated. The term *step polymerization* is used for reactions in which no small molecules are eliminated. The term *addition polymerization* is used for reactions in which small molecules are added to the growing chain.

Ring-opening polymerization is a type of addition polymerization. The classification of the polymers obtained from ring-opening polymerization into two classifications cannot always be made. For example, polyamides and polyesters produced in the ring-opening polymerization of lactams and lactones, must be separately classified. These polymers are structurally similar to the corresponding condensation polymers. The classification of these polymers is even more complicated for a polymer that can be obtained from a single monomer, such as caproic acid. It should suffice to say that the classification of polymers based only on polymerization mechanism is an oversimplification that leads to confusion. The classification is needed in order to clearly

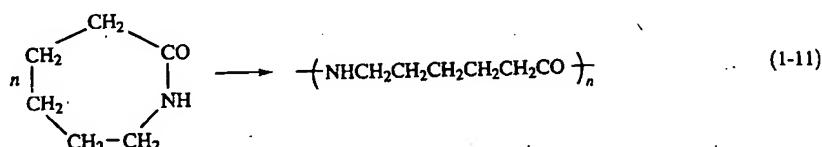
1-2 NOMENCLATURE OF POLYMERS

Polymer nomenclature leaves much to be desired. The chemical structure as is used

The ring-opening polymerizations of cyclic monomers such as propylene oxide



or ϵ -caprolactam



usually proceed by the chain polymerization mechanism, but the dependence of polymer molecular weight on conversion almost never follows the behavior in Fig. 1-1a. Ring-opening polymerizations often follow the behavior in Fig. 1-1c.

The International Union of Pure and Applied Chemistry [IUPAC, 1994] suggested the term *polycondensation* instead of step polymerization, but polycondensation is a narrower term than step polymerization since it implies that the reactions are limited to condensations—reactions in which small molecules such as water are expelled during polymerization. The term step polymerization encompasses not only condensations but also polymerizations in which no small molecules are expelled. An example of the latter is the reaction of diols and diisocyanates to yield polyurethanes (Eq. 1-6). The formation of polyurethanes follows the same reaction characteristics as the formation of polyesters, polyamides, and other polymerizations in which small molecules are expelled.

Ring-opening polymerizations point out very clearly that one must distinguish between the classification of the polymerization mechanism and that of the polymer structure. The two classifications cannot always be used interchangeably. Polymers such as the polyethers and polyamides produced in Eqs. 1-10 and 1-11, as well as those from other cyclic monomers, must be separately classified as to polymerization mechanism and polymer structure. These polymers are structurally classified as condensation polymers, since they contain functional groups (e.g., ether, amide) in the polymer chain. They, like the polyurethanes, are not classified as addition polymers by the use of Carothers' original classification. The situation is even more complicated for a polymer such as that obtained from ϵ -caprolactam. The exact same polymer can be obtained by the step polymerization of the linear monomer ϵ -aminocaproic acid. It should suffice at this point to stress that the terms condensation and step polymer or polymerization are not synonymous nor are the terms addition and chain polymer or polymerization, even though these terms are often used interchangeably. The classification of polymers based only on polymer structure or only on polymerization mechanism is often an oversimplification that leads to ambiguity and error. Both structure and mechanism are usually needed in order to clearly classify a polymer.

1-2 NOMENCLATURE OF POLYMERS

Polymer nomenclature leaves much to be desired. A standard nomenclature system based on chemical structure as is used for small inorganic and organic compounds is most desired.

nerization; (b) step polymeriza-

erved in certain chain poly-
the absence of reactions that
s of proteins also show the
olecules are directed to react
is.

appears unbalanced and confusing,

(1-9)

on both sides, while Eq. 1-14 has that it is on the left side.

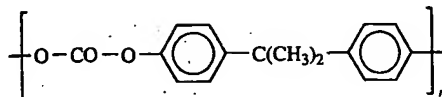
tracts (CA), a journal published by chemical literature and has developed very close to the IUPAC rules, are not important at the level of the mentioned is the placement of the part of the name to which they 4-pyridinediyl instead of pyridine- in the placement of locants in IUPAC name is but-1-ene; the CA placement of locants for small molecules for CRU subunits, but the

used for some polymers. Although those that are firmly established nature is the use of the name nylon natic monomers. Two numbers are indicating the number of methylene bond number the number of carbon (ipamide) and poly(hexamethylene ly. Variants of these names are ons of nylon 6,6 as nylon 66, 66 rom single monomers are denoted ms in the repeating unit. Poly(e-

ature conveys very little meaning polymers, in fact, seem not to have ion of formaldehyde and phenol is nol-formaldehyde resin, phenolic, e or other aldehydes with urea or oplasts without any more specific aldehyde and which amino mono- ing referred to as an *amino resin*. rformed by indicating the two reac- amine-formaldehyde resin.

other polymers. Thus the polymer isphenol A" or *polycarbonate*. The

IUPAC name for this polymer is poly(oxycarbonyloxy-1,4-phenylenedimethylmethylen-1,4-phenylene).



XXVII

1-3 LINEAR, BRANCHED, AND CROSSLINKED POLYMERS

Polymers can be classified as *linear*, *branched*, or *crosslinked* polymers depending on their structure. In the previous discussion on the different types of polymers and polymerizations we have considered only those polymers in which the monomer molecules have been linked together in one continuous length to form the polymer molecule. Such polymers are termed

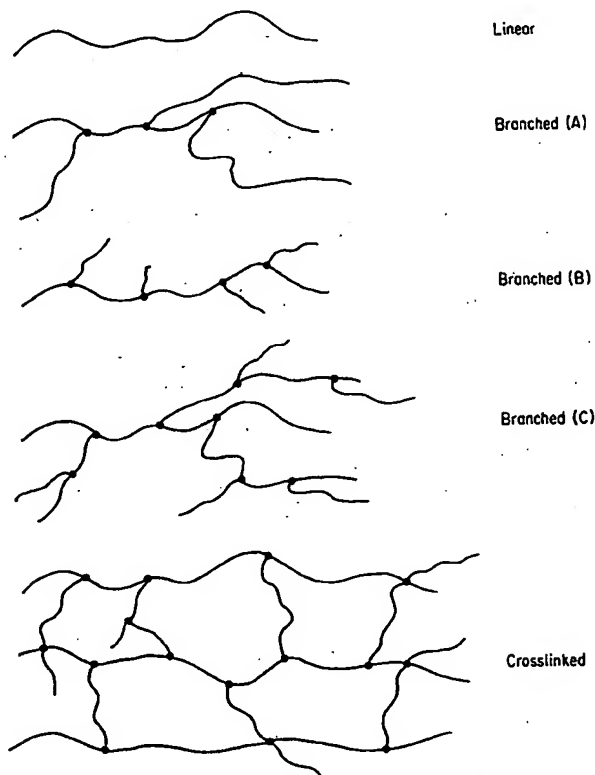
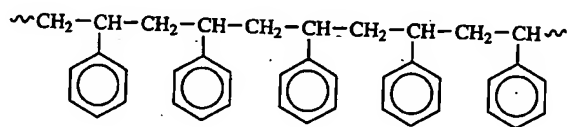


Fig. 1-2 Structure of linear, branched, and crosslinked polymers.

linear polymers. Under certain reaction conditions or with certain kinds of monomers the polymers can be quite different.

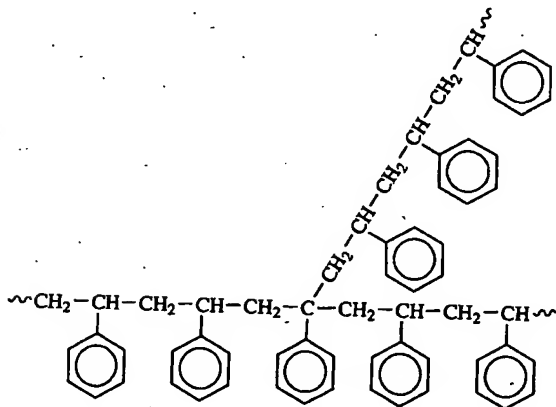
Branched polymers, polymers with more than two chain ends per molecule, can form in both step and chain polymerizations. Branched polymer molecules are those in which there are side branches of linked monomer molecules protruding from various central branch points along the main polymer chain. The difference between the shapes of linear and branched polymer molecules can be seen from the structural representations in Fig. 1-2. The branch points are indicated by heavy dots. The illustrations show that there are several different kinds of branched polymers. The branched polymer can be comblike in structure with either long (A) or short (B) branches. When there is extensive branching, the polymer can have a dendritic structure in which there are branches protruding from other branches, that is, branched branches (C). The presence of branching in a polymer usually has a large effect on many important polymer properties. The most significant property change brought about by branching is the decrease in crystallinity. Branched polymers do not pack as easily into a crystal lattice as do linear polymers.

It is important to point out that the term *branched polymer* does not refer to linear polymers containing side groups that are part of the monomer structure. Only those polymers that contain side branches composed of complete monomer units are termed *branched polymers*. Thus polystyrene XXVIII is classified as a linear polymer, and not as a branched polymer,



XXVIII

because the phenyl groups are part of the monomer unit and are not considered as branches. Branched polystyrene would be the polymer XXIX in which one has one or more polystyrene branches protruding from the main linear polystyrene chain.



XXIX

When polymers are produced at points other than their ends, it can be made to occur during the reaction. It can also be brought about by crosslinks between polymer chains, and the specific conditions as to obtain lightly or highly crosslinked polymers. A three-dimensional network of polymer chains in a sample of rubber. High degrees of crosslinking is used to impart elasticity (under conditions of heat). Urea-formaldehyde polymers

1-4 MOLECULAR WEIGHT

The molecular weight of a polymer is a function of its application. Chemists usually use the term molecular weight. The more accurate term is the ratio of the average molecular weight of the polymer to the atomic weight of ^{12}C and is dimensionless throughout irrespective of the term for most chemists.

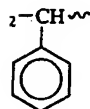
The interesting and useful properties of polymeric materials are a consequence of their molecular weight. There is a minimum molecular weight until a critical point (E) is reached and eventually reaches a limit. The minimum molecular weight is useful. Most practical applications require higher strengths. The minimum molecular weight, 10,000, differs for different polymers as the magnitude of the intermolecular forces.



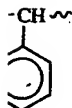
Fig. 1-3 Dependence

with certain kinds of monomers the chain ends per molecule, can form in molecules are those in which there protruding from various central branch between the shapes of linear and structural representations in Fig. 1-2. Illustrations show that there are several polymer can be comblike in structure is extensive branching, the polymer has protruding from other branches, giving in a polymer usually has a large significant property change brought about. Branched polymers do not pack as easily

polymer does not refer to linear polymer structure. Only those polymers that units are termed *branched polymers*, and not as a branched polymer,



and are not considered as branches. Each one has one or more polystyrene chain.



When polymers are produced in which the polymer molecules are linked to each other at points other than their ends, the polymers are said to be *crosslinked* (Fig. 1-2). Crosslinking can be made to occur during the polymerization process by the use of appropriate monomers. It can also be brought about after the polymerization by various chemical reactions. The crosslinks between polymer chains can be of different lengths depending on the crosslinking method and the specific conditions employed. One can also vary the number of crosslinks so as to obtain lightly or highly crosslinked polymers. When the number of crosslinks is sufficiently high, a *three-dimensional* or *space network* polymer is produced in which all the polymer chains in a sample have been linked together to form one giant molecule. Light crosslinking is used to impart good recovery (elastic) properties to polymers to be used as rubbers. High degrees of crosslinking are used to impart high rigidity and dimensional stability (under conditions of heat and stress) to polymers such as the phenol-formaldehyde and urea-formaldehyde polymers.

1-4 MOLECULAR WEIGHT

The molecular weight of a polymer is of prime importance in the polymer's synthesis and application. Chemists usually use the term *molecular weight* to describe the size of a molecule. The more accurate term is molar mass, usually in units of g mol^{-1} . The term molecular weight is the ratio of the average mass per formula unit of a substance to $\frac{1}{12}$ th of the mass of an atom of ^{12}C and is dimensionless (IUPAC, 1991, in press). This text will use *molecular weight* throughout irrespective of the units, because molecular weight is the more familiar term for most chemists.

The interesting and useful mechanical properties that are uniquely associated with polymeric materials are a consequence of their high molecular weight. Most important mechanical properties depend on and vary considerably with molecular weight as seen in Fig. 1-3. There is a minimum polymer molecular weight (A), usually a thousand or so, to produce any significant mechanical strength at all. Above A, strength increases rapidly with molecular weight until a critical point (B) is reached. Mechanical strength increases more slowly above B and eventually reaches a limiting value (C). The critical point B generally corresponds to the minimum molecular weight for a polymer to begin to exhibit sufficient strength to be useful. Most practical applications of polymers require higher molecular weights to obtain higher strengths. The minimum useful molecular weight (B), usually in the range 5000–10,000, differs for different polymers. The plot in Fig. 1-3 generally shifts to the right as the magnitude of the intermolecular forces decreases. Polymer chains with stronger

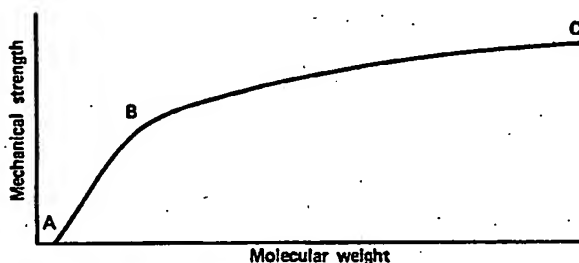


Fig. 1-3 Dependence of mechanical strength on polymer molecular weight.

intermolecular forces, for example, polyamides and polyesters, develop sufficient strength to be useful at lower molecular weights than polymers having weaker intermolecular forces, for example, polyethylene.

Properties other than strength also show a significant dependence on molecular weight. However, most properties show different quantitative dependencies on molecular weight. Different polymer properties usually reach their optimum values at different molecular weights. Further, a few properties may increase with molecular weight to a maximum value and then decrease with further increase in molecular weight. An example is the ability to process polymers into useful articles and forms (e.g., film, sheet, pipe, fiber). Processability begins to decrease past some molecular weight as the viscosity becomes too high and melt flow too difficult. Thus the practical aspect of a polymerization requires one to carry out the process to obtain a compromise molecular weight—a molecular weight sufficiently high to obtain the required strength for a particular application without overly sacrificing other properties. Synthesizing the highest possible molecular weight is not necessarily the objective of a typical polymerization. Instead, one often aims to obtain a high but specified, compromise molecular weight. The utility of a polymerization is greatly reduced unless the process can be carried out to yield the specified molecular weight. The control of molecular weight is essential for the practical application of a polymerization process.

When one speaks of the molecular weight of a polymer, one means something quite different from that which applies to small-sized compounds. Polymers differ from the small-sized compounds in that they are polydisperse or heterogeneous in molecular weight. Even if a polymer is synthesized free from contaminants and impurities, it is still not a pure substance in the usually accepted sense. Polymers, in their purest form, are mixtures of molecules of different molecular weight. The reason for the polydispersity of polymers lies in the statistical variations present in the polymerization processes. When one discusses the molecular weight of a polymer, one is actually involved with its average molecular weight. Both the average molecular weight and the exact distribution of different molecular weights within a polymer are required in order to fully characterize it. The control of molecular weight and molecular weight distribution (MWD) is often used to obtain and improve certain desired physical properties in a polymer product.

Various methods based on solution properties are used to determine the average molecular weight of a polymer sample. These include methods based on colligative properties, light scattering, and viscosity [Heimenz, 1984; Morawetz, 1975; Slade, 1998; Sperling, 2001]. The various methods do not yield the same average molecular weight. Different average molecular weights are obtained because the properties being measured are biased differently toward the different-sized polymer molecules in a polymer sample. Some methods are biased toward the larger-sized polymer molecules, while other methods are biased toward the smaller-sized molecules. The result is that the average molecular weights obtained are correspondingly biased toward the larger- or smaller-sized molecules. The following average molecular weights are determined:

1. The *number-average molecular weight* \bar{M}_n is determined by experimental methods that count the number of polymer molecules in a sample of the polymer. The methods for measuring \bar{M}_n are those that measure the colligative properties of solutions—vapor pressure lowering (vapor pressure osmometry), freezing point depression (cryoscopy), boiling point elevation (ebulliometry), and osmotic pressure (membrane osmometry). The colligative properties are the same for small and large molecules when comparing solutions at the same molal (or mole fraction) concentration. For example, a 1-molal solution of a polymer of molecular weight 10^5 has the same vapor pressure, freezing point, boiling point, and osmotic

pressure as a 1-molal solution of a small molecule such as hexan. A polymer sample divided by its molecular weight is

$$\bar{M}_n = \frac{w}{\sum N_x} = \frac{\sum N_x M_x}{\sum N_x}$$

where the summations are over $x = \infty$ and N_x is the number of molecules written as

$$\bar{M}_n = \sum N_x M_x$$

where N_x is the mole fraction. Common methods for measuring \bar{M}_n are vapor pressure osmometry, which measures the temperature of a polymer solution, and light scattering. Polymers with \bar{M}_n below 10,000–100,000 measured by osmometry become too small to measure by light scattering, limited to polymers with \bar{M}_n at least 10,000. Above molecular weight 100,000, \bar{M}_n becomes too small to measure by light scattering. For certain polymers, \bar{M}_n is determined by titration with base or by ^1H NMR. Accurate end-group analysis is possible for 20,000–30,000.

2. Light scattering by polymers of larger-sized molecules than 100,000 is obtained from light-scattering methods defined as

$$\bar{M}_w = \sum w_x M_x$$

where w_x is the weight fraction

$$\bar{M}_w = \frac{\sum c_x M_x}{\sum c_x} = \frac{\sum c_x M_x}{c}$$

where c_x is the weight concentration of all the polymer molecules, and

$$w_x = \frac{c_x}{c}$$

$$c_x = N_x M_x$$

$$c = \sum c_x = \sum N_x M_x$$

develop sufficient strength to
overcome intermolecular forces, for

dependence on molecular weight.
variations on molecular weight.
values at different molecular
weight to a maximum value

An example is the ability to
draw (e.g., pipe, fiber). Processability
becomes too high and melt
strength requires one to carry out the
draw weight sufficiently high to
without overly sacrificing other
properties. This is not necessarily the objec-
tive in a high but specified, com-
position. The control of molecular
weight is greatly reduced unless the
draw weight is controlled. The control of molecular
weight is a process.

It means something quite dif-
ferent. Polymers differ from the small-
molecules in molecular weight.
and impurities, it is still not a
purest form, are mixtures
of polydispersity of polymers
processes. When one discusses
with its average molecular
weight, the control of mole-
cular weight is used to obtain and improve.

to determine the average molecular
weight. Colligative properties, light
scattering, [Lade, 1998; Sperling, 2001].
molecular weight. Different average
weights are biased differently
weight. Some methods are biased
toward the molecular weights obtained are
molecular weights. The following average

can be determined by experimental methods
for a polymer. The methods for
determination of solutions—vapor pressure
osmometry (cryoscopy), boiling point
osmometry). The colligative
properties of solutions at the same
molecular solution of a polymer of
weight, boiling point, and osmotic

pressure as a 1-molal solution of a polymer of molecular weight 10^3 or a 1-molal solution of
a small molecule such as hexane. \bar{M}_n is defined as the total weight w of all the molecules in a
polymer sample divided by the total number of moles present. Thus the number-average
molecular weight is

$$\bar{M}_n = \frac{w}{\sum N_x} = \frac{\sum N_x M_x}{\sum N_x} \quad (1-15)$$

where the summations are over all the different sizes of polymer molecules from $x = 1$
to $x = \infty$ and N_x is the number of moles whose weight is M_x . Equation 1-15 can also be
written as

$$\bar{M}_n = \sum N_x M_x \quad (1-16)$$

where N_x is the mole fraction (or the number-fraction) of molecules of size M_x . The most
common methods for measuring \bar{M}_n are membrane osmometry and vapor pressure osmome-
try since reasonably reliable commercial instruments are available for those methods. Vapor
pressure osmometry, which measures vapor pressure indirectly by measuring the change in
temperature of a polymer solution on dilution by solvent vapor, is generally useful for poly-
mers with \bar{M}_n below 10,000–15,000. Above that molecular weight limit, the quantity being
measured becomes too small to detect by the available instruments. Membrane osmometry is
limited to polymers with \bar{M}_n above about 20,000–30,000 and below 500,000. The lower limit
is a consequence of the partial permeability of available membranes to smaller-sized polymer
molecules. Above molecular weights of 500,000, the osmotic pressure of a polymer solution
becomes too small to measure accurately. End-group analysis is also useful for measurements
of \bar{M}_n for certain polymers. For example, the carboxyl end groups of a polyester can be ana-
lyzed by titration with base and carbon-carbon double bond end groups can be analyzed by
 ^1H NMR. Accurate end-group analysis becomes difficult for polymers with \bar{M}_n values above
20,000–30,000.

2. Light scattering by polymer solutions, unlike colligative properties, is greater for
larger-sized molecules than for smaller-sized molecules. The average molecular weight
obtained from light-scattering measurements is the *weight-average molecular weight* \bar{M}_w
defined as

$$\bar{M}_w = \sum w_x M_x \quad (1-17)$$

where w_x is the weight fraction of molecules whose weight is M_x . \bar{M}_w can also be defined as

$$\bar{M}_w = \frac{\sum c_x M_x}{\sum c_x} = \frac{\sum c_x M_x}{c} = \frac{\sum N_x M_x^2}{\sum N_x M_x} \quad (1-18)$$

where c_x is the weight concentration of M_x molecules, c is the total weight concentration of
all the polymer molecules, and the following relationships hold:

$$w_x = \frac{c_x}{c} \quad (1-19)$$

$$c_x = N_x M_x \quad (1-20)$$

$$c = \sum c_x = \sum N_x M_x \quad (1-21)$$

Since the amount of light scattered by a polymer solution increases with molecular weight, this method becomes more accurate for higher polymer molecular weights. There is no upper limit to the molecular weight that can be accurately measured except the limit imposed by insolubility of the polymer. The lower limit of \bar{M}_w by the light scattering method is close to 5000–10,000. Below this molecular weight, the amount of scattered light is too small to measure accurately.

3. Solution viscosity is also useful for molecular-weight measurements. Viscosity, like light scattering, is greater for the larger-sized polymer molecules than for smaller ones. However, solution viscosity does not measure \bar{M}_w since the exact dependence of solution viscosity on molecular weight is not exactly the same as light scattering. Solution viscosity measures the *viscosity-average molecular weight* \bar{M}_v defined by

$$\bar{M}_v = \left[\sum w_x M_x^a \right]^{1/a} = \left[\frac{\sum N_x M_x^{a+1}}{\sum N_x M_x} \right]^{1/a} \quad (1-22)$$

where a is a constant. The viscosity- and weight-average molecular weights are equal when a is unity. \bar{M}_v is less than \bar{M}_w for most polymers, since a is usually in the range 0.5–0.9. However, \bar{M}_v is much closer to \bar{M}_w than \bar{M}_n , usually within 20% of \bar{M}_w . The value of a is dependent on the hydrodynamic volume of the polymer, the effective volume of the solvated polymer molecule in solution, and varies with polymer, solvent, and temperature.

More than one average molecular weight is required to reasonably characterize a polymer sample. There is no such need for a monodisperse product (i.e., one composed of molecules whose molecular weights are all the same) for which all three average molecular weights are the same. The situation is quite different for a polydisperse polymer where all three molecular weights are different if the constant a in Eq. 1-22 is less than unity, as is the usual case. A careful consideration of Eqs. 1-15 through 1-22 shows that the number-, viscosity-, and weight-average molecular weights, in that order, are increasingly biased toward the higher-molecular-weight fractions in a polymer sample. For a polydisperse polymer

$$\bar{M}_w > \bar{M}_v > \bar{M}_n$$

with the differences between the various average molecular weights increasing as the molecular-weight distribution broadens. A typical polymer sample will have the molecular-weight distribution shown in Fig. 1-4. The approximate positions of the different average molecular weights are indicated on this distribution curve.

For most practical purposes, one usually characterizes the molecular weight of a polymer sample by measuring \bar{M}_n and either \bar{M}_w or \bar{M}_v . \bar{M}_v is commonly used as a close approximation of \bar{M}_w , since the two are usually quite close (within 10–20%). Thus in most instances, one is concerned with the \bar{M}_n and \bar{M}_w of a polymer sample. The former is biased toward the lower-molecular-weight fractions, while the latter is biased toward the higher-molecular-weight fractions. The ratio of the two average molecular weights \bar{M}_w/\bar{M}_n depends on the breadth of the distribution curve (Fig. 1-4) and is often useful as a measure of the polydispersity in a polymer. The value of \bar{M}_w/\bar{M}_n would be unity for a perfectly monodisperse polymer. The ratio is greater than unity for all actual polymers and increases with increasing polydispersity.

The characterization of a polymer by \bar{M}_n alone, without regard to the polydispersity, can be extremely misleading, since most polymer properties such as strength and melt viscosity are determined primarily by the size of the molecules that make up the bulk of the sample by weight. Polymer properties are much more dependent on the larger-sized molecules in a

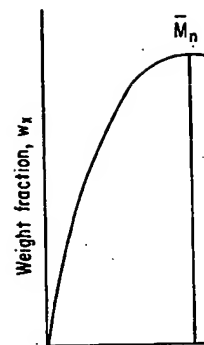


Fig. 1-4 Distribution

sample than on the smaller ones including 95% by weight of molecular weight 100. (The low-mol weight polymer, or simply some and 1-17 as 1680 and 9505, respectively, indicate the properties of primarily by the 10,000-mol the mixture. The weight-average to be expected in a polymer. The tion of polydispersity in a sam

In addition to the different quently desirable and necessary cated previously, there is usual property will be optimum for : greatest percentage of polymer value of the desired property. ! possess different molecular v allows the proper choice of a been used in the past to deter including fractional extraction determinations of molecular w development of *size exclusion chromatography* (GPC) and the ged the situation. Molecular-laboratories using SEC.

Size exclusion chromatogr column packed with micropor 1996; Yau et al., 1979]. The p cules pass through the column through the interstitial volum beads are slowed down more i trate the beads; in other words,

increases with molecular weight, molecular weights. There is no upper limit except the limit imposed by light scattering method is close to scattered light is too small to mea-

measurements. Viscosity, like all other properties, is more sensitive to changes than for smaller ones. How does the dependence of solution viscosity on molecular weight change with increasing molecular weight. Solution viscosity measures

(1-22)

molecular weights are equal when a is usually in the range 0.5–0.9. How does the value of a depend on the effective volume of the solvated polymer, and temperature.

reasonably characterize a polymer i.e., one composed of molecules of a single average molecular weight. The average molecular weights are \bar{M}_n and \bar{M}_w . In a polymer where all three molecular weights are equal, the molecular weight is unity, as is the usual case. But the number-, viscosity-, and weight-average molecular weights are increasingly biased toward the higher molecular weight in a polydisperse polymer.

molecular weights increasing as the molecular weight of the sample will have the molecular weight distributions of the different average molecular weights.

the molecular weight of a polymer sample is commonly used as a close approximation (within 0–20%). Thus in most instances, the weight-average molecular weight is biased toward the higher molecular weights. The former is biased toward the higher molecular weights. The ratio \bar{M}_w/\bar{M}_n depends on the molecular weight distribution as a measure of the polydispersity of a perfectly monodisperse polymer and increases with increasing molecular weight.

regard to the polydispersity, can be measured as strength and melt viscosity. The larger the bulk of the sample by the larger-sized molecules in a

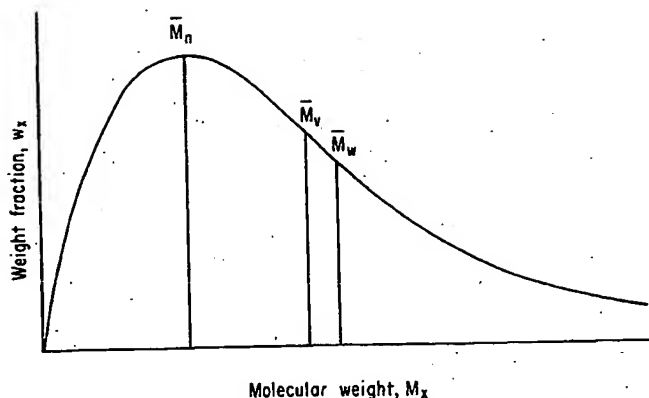


Fig. 1-4 Distribution of molecular weights in a typical polymer sample.

sample than on the smaller ones. Thus, for example, consider a hypothetical mixture containing 95% by weight of molecules of molecular weight 10,000, and 5% of molecules of molecular weight 100. (The low-molecular-weight fraction might be monomer, a low-molecular-weight polymer, or simply some impurity.) The \bar{M}_n and \bar{M}_w are calculated from Eqs. 1-15 and 1-17 as 1680 and 9505, respectively. The use of the \bar{M}_n value of 1680 gives an inaccurate indication of the properties of this polymer. The properties of the polymer are determined primarily by the 10,000-molecular-weight molecules that make up 95% of the weight of the mixture. The weight-average molecular weight is a much better indicator of the properties to be expected in a polymer. The utility of \bar{M}_n resides primarily in its use to obtain an indication of polydispersity in a sample by measuring the ratio \bar{M}_w/\bar{M}_n .

In addition to the different average molecular weights of a polymer sample, it is frequently desirable and necessary to know the exact distribution of molecular weights. As indicated previously, there is usually a molecular weight range for which any given polymer property will be optimum for a particular application. The polymer sample containing the greatest percentage of polymer molecules of that size is the one that will have the optimum value of the desired property. Since samples with the same average molecular weight may possess different molecular weight distributions, information regarding the distribution allows the proper choice of a polymer for optimum performance. Various methods have been used in the past to determine the molecular weight distribution of a polymer sample, including fractional extraction and fractional precipitation. These methods are laborious and determinations of molecular weight distributions were not routinely performed. However, the development of *size exclusion chromatography* (SEC), also referred to as *gel permeation chromatography* (GPC) and the availability of automated commercial instruments have changed the situation. Molecular-weight distributions are now routinely performed in most laboratories using SEC.

Size exclusion chromatography involves the permeation of a polymer solution through a column packed with microporous beads of crosslinked polystyrene [Potschka and Dublin, 1996; Yau et al., 1979]. The packing contains beads of different-sized pore diameters. Molecules pass through the column by a combination of transport into and through the beads and through the interstitial volume (the volume between beads). Molecules that penetrate the beads are slowed down more in moving through the column than molecules that do not penetrate the beads; in other words, transport through the interstitial volume is faster than through

the pores. The smaller-sized polymer molecules penetrate all the beads in the column since their molecular size (actually their hydrodynamic volume) is smaller than the pore size of the beads with the smallest-sized pores. A larger-sized polymer molecule does not penetrate all the beads since its molecular size is larger than the pore size of some of the beads. The larger the polymer molecular weight, the fewer beads that are penetrated and the greater is the extent of transport through the interstitial volume. The time for passage of polymer molecules through the column decreases with increasing molecular weight. The use of an appropriate detector (refractive index, viscosity, light scattering) measures the amount of polymer passing through the column as a function of time. This information and a calibration of the column with standard polymer samples of known molecular weight allow one to obtain the molecular weight distribution in the form of a plot such as that in Fig. 1-4. Not only does SEC yield the molecular weight distribution, but \bar{M}_n and \bar{M}_w (and also \bar{M}_v if a is known) are also calculated automatically. SEC is now the method of choice for measurement of \bar{M}_n and \bar{M}_w , since the SEC instrument is far easier to use compared to methods such as osmometry and light scattering.

1-5 PHYSICAL STATE

1-5a Crystalline and Amorphous Behavior

Solid polymers differ from ordinary, low-molecular-weight compounds in the nature of their physical state or *morphology*. Most polymers show simultaneously the characteristics of both crystalline and amorphous solids [Keller et al., 1995; Mark et al., 1993; Porter and Wang, 1995; Sperling, 2001; Woodward, 1989; Wunderlich, 1973]. X-Ray and electron diffraction patterns often show the sharp features typical of three-dimensionally ordered crystalline solids as well as the diffuse, unordered features characteristic of amorphous solids. (Amorphous solids have sometimes been referred to as highly viscous liquids.) The terms *crystalline* and *amorphous* are used to indicate the ordered and unordered polymer regions, respectively. Different polymers show different degrees of crystalline behavior. The known polymers constitute a spectrum of materials from those that are completely amorphous to others that possess low to moderate to high crystallinity. The term *semicrystalline* is used to refer to polymers that are partially crystalline. Completely crystalline polymers are rarely encountered.

The exact nature of polymer crystallinity has been the subject of considerable controversy. The *fringed-micelle* theory, developed in the 1930s, considers polymers to consist of small-sized, ordered crystalline regions—termed *crystallites*—imbedded in an unordered, amorphous polymer matrix. Polymer molecules are considered to pass through several different crystalline regions with crystallites being formed when extended-chain segments from different polymer chains are precisely aligned together and undergo crystallization. Each polymer chain can contribute ordered segments to several crystallites. The segments of the chain in between the crystallites make up the unordered amorphous matrix. This concept of polymer crystallinity is shown in Fig. 1-5.

The *folded-chain lamella* theory arose in the last 1950s when polymer single crystals in the form of thin platelets termed *lamella*, measuring about $10,000 \text{ \AA} \times 100 \text{ \AA}$, were grown from polymer solutions. Contrary to previous expectations, X-ray diffraction patterns showed the polymer chain axes to be parallel to the smaller dimension of the platelet. Since polymer molecules are much longer than 100 \AA , the polymer molecules are presumed to fold back and forth on themselves in an accordionlike manner in the process of crystallization. Chain



Fig. 1-5 Fri

folding was unexpected, since the completely extended chains. The apparently the system's compromise crystallization conditions. The is regular and sharp with a uniform the *nonadjacent-reentry* or *switch* regular surface of a lamella before chain-folded lamella picture of polymer to defects in the chain-folding process packing, chain entanglements, localous other imperfections. The adjacent

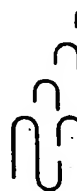


Fig. 1-6

all the beads in the column since is smaller than the pore size of the or molecule does not penetrate all e of some of the beads. The larger penetrated and the greater is the me for passage of polymer molecular weight. The use of an appo- measures the amount of polymer formation and a calibration of the ar weight allow one to obtain the as that in Fig. 1-4. Not only does \bar{M}_w (and also \bar{M}_n if a is known) are hoice for measurement of \bar{M}_n and d to methods such as osmometry

t compounds in the nature of their neously the characteristics of both rk et al., 1993; Porter and Wang, 3]. X-Ray and electron diffraction dimensionally ordered crystalline istic of amorphous solids. (Amor- scous liquids.) The terms *crystal-* and unordered polymer regions, f crystalline behavior. The known hat are completely amorphous to The term *semicrystalline* is used ely crystalline polymers are rarely

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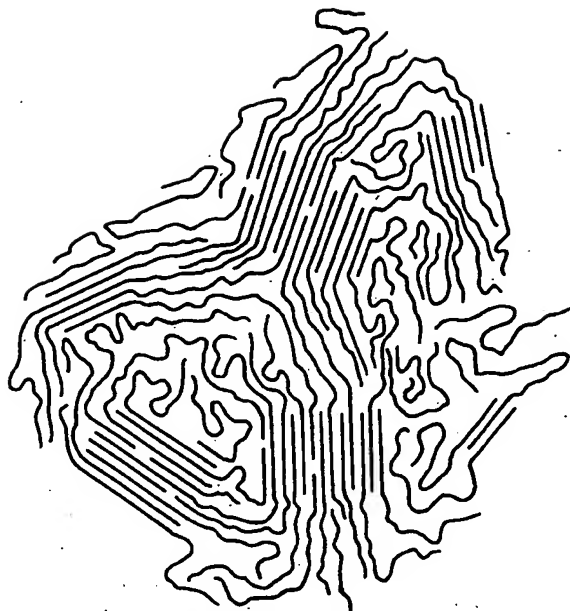


Fig. 1-5 Fringed-micelle model of polymer crystallinity.

folding was unexpected, since the most thermodynamically stable crystal is the one involving completely extended chains. The latter is kinetically difficult to achieve and chain folding is apparently the system's compromise for achieving a highly stable crystal structure under normal crystallization conditions. Two models of chain folding can be visualized. Chain folding is regular and sharp with a uniform fold period in the *adjacent-reentry* model (Fig. 1-6). In the *nonadjacent-reentry* or *switchboard* model (Fig. 1-7) molecules wander through the non-regular surface of a lamella before reentering the lamella or a neighboring lamella. In the chain-folded lamella picture of polymer crystallinity less than 100% crystallinity is attributed to defects in the chain-folding process. The defects may be imperfect folds, irregularities in packing, chain entanglements, loose chain ends, dislocations, occluded impurities, or numerous other imperfections. The adjacent reentry and switchboard models differ in the details of

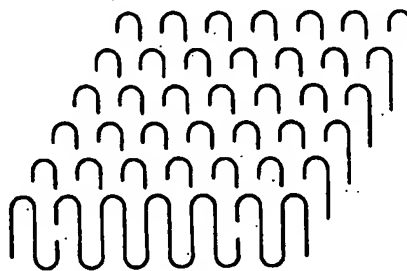


Fig. 1-6. Adjacent reentry model of single crystal.

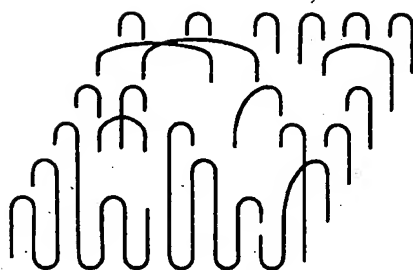


Fig. 1-7 Switchboard model of single crystal.

what constitutes the chain-folding defects. The switchboard model indicates that most defects are at the crystal surfaces, while the adjacent-reentry model indicates that defects are located as much within the crystal as at the crystal surfaces.

Folded-chain lamella represent the morphology not only for single crystals grown from solution but also polymers crystallized from the melt—which is how almost all commercial and other synthetic polymers are obtained. Melt-crystallized polymers have the most prominent structural feature of polymer crystals—the chains are oriented perpendicular to the lamella face so that chain folding must occur. Chain folding is maximum for polymers crystallized slowly near the crystalline melting temperature. Fast cooling (quenching) gives a more chaotic crystallization with less chain folding. Melt crystallization often develops as a spherical or spherulitic growth as seen under the microscope. Nucleation of crystal growth occurs at various nuclei and crystal growth proceeds in a radial fashion from each nucleus until the growth fronts from neighboring structures impinge on each other. These spherical structures, termed *spherulites*, completely fill the volume of a crystallized polymer sample. Spherulites have different sizes and degrees of perfection depending on the specific polymer and crystallization conditions.

A spherulite is a complex, polycrystalline structure (Fig. 1-8). The *nucleus* for spherulitic growth is the single crystal in which a multilayered stack is formed, and each lamella extends to form a *lamellar fibril*. The flat ribbonlike lamellar fibrils diverge, twist, and branch as they grow outward from the nucleus. Growth occurs by chain folding with the polymer chain axes being perpendicular to the length of the lamellar fibril. The strength of polymers indicates that more than van der Waals forces hold lamellae together. There are *interlamellar* or *intercrystalline fibrils* (also termed *tie molecules*) between the lamellar fibrils within a spherulite and between fibrils of different spherulites. Some polymer molecules simultaneously participate in the growth of two or more adjacent lamellae and provide molecular links that reinforce the crystalline structure. The chain axes of tie molecules lie parallel to the long axes of the link—each link between lamellae is an extended-chain type of single crystal. The tie molecules are the main component of the modern picture of polymer crystallinity, which is a carryover from the fringed-micelle theory. The amorphous content of a semicrystalline, melt-crystallized polymer sample consists of the defects in the chain-folding structure, tie molecules, and the material that is either, because of entanglements, not included in the growing lamellar fibril or is rejected from it owing to its unacceptable nature; low-molecular-weight chains and nonregular polymer chain segments, for example, are excluded.

Some natural polymers such as cotton, silk, and cellulose have the extended-chain morphology, but their morphologies are determined by enzymatically controlled synthesis and crystallization processes. Extended-chain morphology is obtained in some synthetic

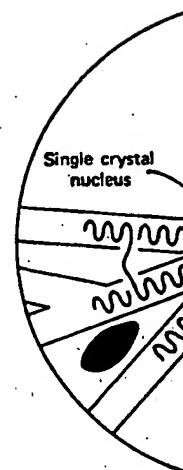


Fig. 1-8 Structural organization of a spherulite.

polymers under certain circumstances. Annealing for long time periods of polymers from the liquid crystalline phase, including polyethylene polymers containing stiff or rigid segments (Sec. 2-8f). Extended-chain morphology is the result of conversion of crystalline monomers (Sec. 3-16c).

A variety of techniques have been used to study polymer crystallinity, including X-ray diffractometry [Wunderlich, 1973]. X-ray diffraction is a difficult separation of the crystalline and amorphous phases but are easily done by X-ray diffraction. Heat of fusion analysis instruments are commonly used [1994; Wendlandt, 1986]. The calorimetry and differential scanning calorimetry (DSC) technique is to calibrate the melting point by X-ray diffraction.

1-5b Determinants of Polymer Crystallinity

Regardless of the precise picture that should be emphasized is that crystallization tendency plays a major role. This is a consequence

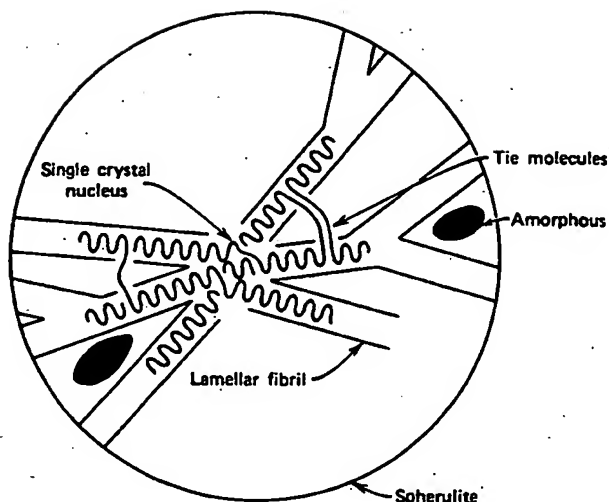


Fig. 1-8 Structural organization within a spherulite in melt-crystallized polymer.

polymers under certain circumstances. These include crystallization from the melt (or annealing for long time periods) under pressure or other applied stress and crystallization of polymers from the liquid crystalline state. The former has been observed with several polymers, including polyethylene and polytetrafluoroethylene. The latter is observed with polymers containing stiff or rigid-rod chains, such as poly(*p*-phenyleneterephthalamide) (Sec. 2-8f). Extended-chain morphology is also obtained in certain polymerizations involving conversion of crystalline monomer to crystalline polymer, for example, polymerization of diacetylenes (Sec. 3-16c).

A variety of techniques have been used to determine the extent of crystallinity in a polymer, including X-ray diffraction, density, IR, NMR, and heat of fusion [Sperling, 2001; Wunderlich, 1973]. X-ray diffraction is the most direct method but requires the somewhat difficult separation of the crystalline and amorphous scattering envelopes. The other methods are indirect methods but are easier to use since one need not be an expert in the field as with X-ray diffraction. Heat of fusion is probably the most often used method since reliable thermal analysis instruments are commercially available and easy to use [Bershtein and Egorov, 1994; Wendlandt, 1986]. The difficulty in using thermal analysis (differential scanning calorimetry and differential thermal analysis) or any of the indirect methods is the uncertainty in the values of the quantity measured (e.g., the heat of fusion per gram of sample or density) for 0 and 100% crystalline samples since such samples seldom exist. The best technique is to calibrate the method with samples whose crystallinities have been determined by X-ray diffraction.

1-5b Determinants of Polymer Crystallinity

Regardless of the precise picture of order and disorder in polymers, the prime consideration that should be emphasized is that polymers have a tendency to crystallize. The extent of this crystallization tendency plays a most significant role in the practical ways in which polymers are used. This is a consequence of the large effect of crystallinity on the thermal, mechanical,

ystal.

I model indicates that most model indicates that defects

or single crystals grown from s how almost all commercial polymers have the most prominent oriented perpendicular to the maximum for polymers crystallization often develops as Nucleation of crystal growth al fashion from each nucleus 1 each other. These spherical crystallized polymer sample. iding on the specific polymer

). The nucleus for spherulitic ed, and each lamella extends rge, twist, and branch as they with the polymer chain axes length of polymers indicates re are interlamellar or inter-lar fibrils within a spherulite ecules simultaneously parti-de molecular links that rein-e parallel to the long axes of e of single crystal. The tie polymer crystallinity, which content of a semicrystalline, : chain-folding structure, tie itanglements, not included s unacceptable nature; low-, for example, are excluded. ive the extended-chain mor- lly controlled synthesis and tained in some synthetic

and other important properties of polymers. Different polymers have different properties and are synthesized and used differently because of varying degrees of crystallinity. The extent of crystallinity developed in a polymer sample is a consequence of both thermodynamic and kinetic factors. In this discussion we will note the general tendency to crystallize under moderate crystallization conditions (that is, conditions that exclude extremes of time, temperature, and pressure). Thermodynamically crystallizable polymers generally must crystallize at reasonable rates if crystallinity is to be employed from a practical viewpoint. The extent to which a polymer crystallizes depends on whether its structure is conducive to packing into the crystalline state and on the magnitude of the secondary attractive forces of the polymer chains. Packing is facilitated for polymer chains that have structural regularity, compactness, streamlining, and some degree of flexibility. The stronger the secondary attractive forces, the greater will be the driving force for the ordering and crystallization of polymer chains.

Some polymers are highly crystalline primarily because their structure is conducive to packing, while others are crystalline primarily because of strong secondary attractive forces. For still other polymers both factors may be favorable for crystallization. Polyethylene, for example, has essentially the best structure in terms of its ability to pack into the crystalline state. Its very simple and perfectly regular structure allows chains to pack tightly and without any restrictions as to which segment of one chain need line up next to which other segment of the same chain or of another chain. The flexibility of the polyethylene chains is also conducive to crystallization in that the conformations required for packing can be easily achieved. Even though its secondary attractive forces are small, polyethylene crystallizes easily and to a high degree because of its simple and regular structure.

Polymers other than polyethylene have less simple and regular chains. Poly(ϵ -caprolactom) can be considered as a modified polyethylene chain containing the amide group in between every five methylenes. Poly(ϵ -caprolactom) and other polyamides are highly crystalline polymers. The amide group is a polar one and leads to much larger secondary attractive forces in polyamides (due to hydrogen bonding) compared to polyethylene; this is most favorable for crystallization. However, the polyamide chains are not as simple as those of polyethylene and packing requires that chain segments be brought together so that the amide groups are aligned. This restriction leads to a somewhat lessened degree of crystallization in polyamides than expected, based only on a consideration of the high secondary attractive forces. Crystallinity in a polymer such as a polyamide can be significantly increased by mechanically stretching it to facilitate the ordering and alignment of polymer chains.

Polymers such as polystyrene, poly(vinyl chloride), and poly(methyl methacrylate) show very poor crystallization tendencies. Loss of structural simplicity (compared to polyethylene) results in a marked decrease in the tendency toward crystallization. Fluorocarbon polymers such as poly(vinyl fluoride), poly(vinylidene fluoride), and polytetrafluoroethylene are exceptions. These polymers show considerable crystallinity since the small size of fluorine does not preclude packing into a crystal lattice. Crystallization is also aided by the high secondary attractive forces. High secondary attractive forces coupled with symmetry account for the presence of significant crystallinity in poly(vinylidene chloride). Symmetry alone without significant polarity, as in polyisobutylene, is insufficient for the development of crystallinity. (The effect of stereoregularity of polymer structure on crystallinity is postponed to Sec. 8-2a.)

Polymers with rigid, cyclic structures in the polymer chain, as in cellulose and poly(ethyleneterephthalate), are difficult to crystallize. Moderate crystallization does occur in these cases, as a result of the polar polymer chains. Additional crystallization can be induced by mechanical stretching. Cellulose is interesting in that native cellulose in the form of cotton is much more crystalline than cellulose that is obtained by precipitation of cellulose from

solution (Sec. 9-3a). The biosynthesized polymer chains in spite of the extensive crosslinking, as in plant cellulose, completely prevents crystallization.

Chain flexibility also effects a polymer chain as in polysiloxanes. The chain conformation is highly flexible of the chains. Rubber is due to the bulky Si— as almost completely amorphous elastic behavior.

1-5c Thermal Transitions

Polymeric materials are characterized by their *crystalline melting temperature*. The melting temperature is the temperature at which the polymer takes on the characteristic rigidity. The difference between the rotational, and vibrational energies of the molecules is essentially zero, or very small, the molecules are able to move. The temperature at which necessary symmetry requirements are met, crystallization does not decrease as the temperature decreases. Long-range motions of the polymer segments, referred to as *segmental motion*, refers to the rotation of bonds at the ends of the chain, $C-CH_3$ and $C-COOCH_3$ bonds.

Whether a polymer sample shows a crystalline morphology. Completely amorphous polymer shows only a T_m . Secondary and glass transition temperatures occur as a polymer undergoes the changes in specific volume. Crystalline polymers (the solid portion of the change in the specific volume involving only a change in the temperature coefficient of the specific volume) corresponding plot for a semicrystalline polymer plus the dotted portion can be used to determine T_g and dynamic mechanical behavior, used method is differential scanning calorimetry as a function of capacity of a sample as a function of temperature.

have different properties and of crystallinity. The extent of both thermodynamic and entropy to crystallize under moderate extremes of time, temperature generally must crystallize from a critical viewpoint. The extent is conducive to packing into the active forces of the polymer intermolecular regularity, compactness, secondary attractive forces, the orientation of polymer chains.

For structure is conducive to secondary attractive forces. Crystallization. Polyethylene, for example, to pack into the crystalline state, to pack tightly and without defects, to which other segment of polyethylene chains is also conducive can be easily achieved. Polyethylene crystallizes easily and to

linear chains. Poly(ϵ -caprolactam) containing the amide group in polyamides are highly crystalline. A larger secondary attractive force in polyethylene; this is, most of all, not as simple as those of polyethylene, so that the amide groups are held together so that the amide groups have a degree of crystallization in the high secondary attractive force; significantly increased by the orientation of polymer chains.

Poly(methyl methacrylate) show a high degree of crystallinity (compared to polyethylene) in the solid state. Fluorocarbon polymers such as polytetrafluoroethylene are also aided by the high symmetry with symmetry account for the high degree of crystallinity. Symmetry alone without the development of crystallinity. Crystallinity is postponed to Sec.

In cellulose and poly(ethylene glycol) crystallization does occur in these polymers. Crystallization can be induced in cellulose in the form of cotton linter, precipitation of cellulose from

solution (Sec. 9-3a). The biosynthesis of cotton proceeds with an enzymatic ordering of the polymer chains in spite of the rigid polymer chains. Excess chain rigidity in polymers due to extensive crosslinking, as in phenol-formaldehyde and urea-formaldehyde polymers, completely prevents crystallization.

Chain flexibility also effects the ability of a polymer to crystallize. Excessive flexibility in a polymer chain as in polysiloxanes and natural rubber leads to an inability of the chains to pack. The chain conformations required for packing cannot be maintained because of the high flexibility of the chains. The flexibility in the cases of the polysiloxanes and natural rubber is due to the bulky Si—O and *cis*-olefin groups, respectively. Such polymers remain as almost completely amorphous materials, which, however, show the important property of elastic behavior.

1-5c Thermal Transitions

Polymeric materials are characterized by two major types of transition temperatures—the crystalline melting temperature T_m and the glass transition temperature T_g . The crystalline melting temperature is the melting temperature of the crystalline domains of a polymer sample. The glass transition temperature is the temperature at which the amorphous domains of a polymer take on the characteristic properties of the glassy state—brittleness, stiffness, and rigidity. The difference between the two thermal transitions can be understood more clearly by considering the changes that occur in a liquid polymer as it is cooled. The translational, rotational, and vibrational energies of the polymer molecules decrease on cooling. When the total energies of the molecules have fallen to the point where the translational and rotational energies are essentially zero, crystallization is possible. If certain symmetry requirements are met, the molecules are able to pack into an ordered, lattice arrangement and crystallization occurs. The temperature at which this occurs is T_m . However, not all polymers meet the necessary symmetry requirements for crystallization. If the symmetry requirements are not met, crystallization does not take place, but the energies of the molecules continue to decrease as the temperature decreases. A temperature is finally reached—the T_g —at which long-range motions of the polymer chains stop. Long-range motion, also referred to as *segmental motion*, refers to the motion of a segment of a polymer chain by the concerted rotation of bonds at the ends of the segment. [Bond rotations about side chains, e.g., the C—CH₃ and C—COOCH₃ bonds in poly(methyl methacrylate), do not cease at T_g .]

Whether a polymer sample exhibits both thermal transitions or only one depends on its morphology. Completely amorphous polymers show only a T_g . A completely crystalline polymer shows only a T_m . Semicrystalline polymers exhibit both the crystalline melting and glass transition temperatures. Changes in properties such as specific volume and heat capacity occur as a polymer undergoes each of the thermal transitions. Figure 1-9 shows the changes in specific volume with temperature for completely amorphous and completely crystalline polymers (the solid lined plots). T_m is a first-order transition with a discontinuous change in the specific volume at the transition temperature. T_g is a second-order transition involving only a change in the temperature coefficient of the specific volume. (A plot of the temperature coefficient of the specific volume versus temperature shows a discontinuity.) The corresponding plot for a semicrystalline polymer consists of the plot for the crystalline polymer plus the dotted portion corresponding to the glass transition. A variety of methods have been used to determine T_g and T_m , including dilatometry (specific volume), thermal analysis, dynamic mechanical behavior, dielectric loss, and broad-line NMR. The most commonly used method is differential scanning calorimetry (DSC). DSC reflects the change in heat capacity of a sample as a function of temperature by measuring the heat flow required to

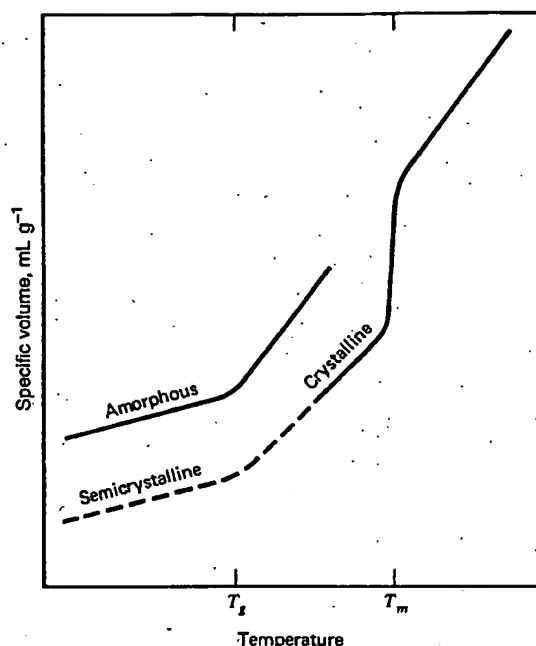


Fig. 1-9 Determination of glass transition and crystalline melting temperatures by changes in specific volume.

maintain a zero temperature differential between an inert reference material and the polymer sample.

The melting of a polymer takes place over a wider temperature range than that observed for small organic molecules such as benzoic acid, due to the presence of different-sized crystalline regions and the more complicated process for melting of large molecules. T_m , generally reported as the temperature for the onset of melting, is determined as the intersection from extrapolation of the two linear regions of Fig. 1-9 (before and after the onset). T_g also occurs over a wide temperature range and is determined by extrapolation of the two linear regions, before and after T_g . The glass transition is a less well understood process than melting. There are indications that it is at least partially a kinetic phenomenon. The experimentally determined value of T_g varies significantly with the timescale of the measurement. Faster cooling rates result in higher T_g values. Further, significant densification still takes place below T_g with the amount dependent on the cooling rate. Perhaps the best visualization of T_g involves the existence of a modest range of temperatures at which there is cessation of segmental motion for polymer chain segments of different lengths (~ 5 – 20 chain atoms).

Some polymers undergo other thermal transitions in addition to T_g and T_m . These include crystal-crystal transitions (i.e., transition from one crystalline form to another and crystalline-liquid crystal transitions).

The values of T_g and T_m for a polymer affect its mechanical properties at any particular temperature and determine the temperature range in which that polymer can be employed. The T_g and T_m values for some of the common polymers are shown in Table 1-3 [Brandrup et al., 1999; Mark, 1999]. (These are the values at 1 atm pressure.) Consider the manner in

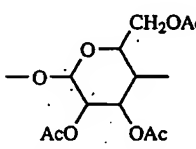
TABLE 1-3 Thermal Transition

Polymer	
Polydimethylsiloxane	—
Polyethylene	—
Polyoxymethylene	—
Natural rubber	—
(polyisoprene)	—
Polyisobutylene	—
Poly(ethylene oxide)	—
Poly(vinylidene fluoride)	—
Polypropene	—
Poly(vinyl fluoride)	—
Poly(vinylidene chloride)	—
Poly(vinyl acetate)	—
Poly(chlorotrifluoroethylene)	—
Poly(ϵ -caprolactam)	—
Poly(hexamethylene adipamide)	—
Poly(ethylene terephthalate)	—
Poly(vinyl chloride)	—
Polystyrene	—
Poly(methyl methacrylate)	—
Cellulose triacetate	—
Polytetrafluoroethylene	—

*Data from Brandrup et al. [1999].

which T_g and T_m vary from simultaneously since both are Polymers with low T_g values usually found together. Polymers pass through the glass transition, since similar considerations. The two thermal transitions are symmetry, structural rigidity, and Mark et al., 1993; Sperling, 2 bonding) lead to strong crystalline attractive forces also

TABLE 1-3 Thermal Transitions of Polymers^a

Polymer	Repeating Unit	T_g (°C)	T_m (°C)
Polydimethylsiloxane	$-\text{OSi}(\text{CH}_3)_2-$	-127	-40
Polyethylene	$-\text{CH}_2\text{CH}_2-$	-125	137
Polyoxymethylene	$-\text{CH}_2\text{O}-$	-83	181
Natural rubber (polyisoprene)	$-\text{CH}_2\text{C}(\text{CH}_3)=\text{CHCH}_2-$	-73	28
Polyisobutylene	$-\text{CH}_2\text{C}(\text{CH}_3)_2-$	-73	44
Poly(ethylene oxide)	$-\text{CH}_2\text{CH}_2\text{O}-$	-53	66
Poly(vinylidene fluoride)	$-\text{CH}_2\text{CF}_2-$	-40	185
Polypropene	$-\text{CH}_2\text{CH}(\text{CH}_3)-$	-1	176
Poly(vinyl fluoride)	$-\text{CH}_2\text{CHF}-$	41	200
Poly(vinylidene chloride)	$-\text{CH}_2\text{CCl}_2-$	-18	200
Poly(vinyl acetate)	$-\text{CH}_2\text{CH}(\text{OCOCH}_3)-$	32	
Poly(chlorotrifluoroethylene)	$-\text{CF}_2\text{CFCl}-$		220
Poly(ϵ -caprolactam)	$-(\text{CH}_2)_5\text{CONH}-$	40	223
Poly(hexamethylene adipamide)	$-\text{NH}(\text{CH}_2)_6\text{NHCO}(\text{CH}_2)_4\text{CO}-$	50	265
Poly(ethylene terephthalate)	$-\text{OCH}_2\text{CH}_2\text{OCO}-\text{C}_6\text{H}_4-\text{CO}-$	61	270
Poly(vinyl chloride)	$-\text{CH}_2\text{CHCl}-$	81	273
Polystyrene	$-\text{CH}_2\text{CH}\phi-$	100	250
Poly(methyl methacrylate)	$-\text{CH}_2\text{C}(\text{CH}_3)(\text{CO}_2\text{CH}_3)-$	105	220
Cellulose triacetate			306
Polytetrafluoroethylene	$-\text{CF}_2\text{CF}_2-$	117	327

^aData from Brandrup et al. [1999].

which T_g and T_m vary from one polymer to another. One can discuss the two transitions simultaneously since both are affected similarly by considerations of polymer structure. Polymers with low T_g values usually have low T_m values; high T_g and high T_m values are usually found together. Polymer chains that do not easily undergo bond rotation so as to pass through the glass transition would also be expected to melt with difficulty. This is reasonable, since similar considerations of polymer structure are operating in both instances. The two thermal transitions are generally affected in the same manner by the molecular symmetry, structural rigidity, and secondary attractive forces of polymer chains [Billmeyer, 1984; Mark et al., 1993; Sperling, 2001]. High secondary forces (due to high polarity or hydrogen bonding) lead to strong crystalline forces requiring high temperatures for melting. High secondary attractive forces also decrease the mobility of amorphous polymer chains, leading to

high T_g . Decreased mobility of polymer chains, increased chain rigidity, and high T_g are found where the chains are substituted with several substituents as in poly(methyl methacrylate) and polytetrafluoroethylene or with bulky substituents as in polystyrene. The T_m values of crystalline polymers produced from such rigid chains would also be high. The effects of substituents are not always easy to understand. A comparison of polypropene, poly(vinyl chloride), and poly(vinyl fluoride) with polyisobutylene, poly(vinylidene chloride), and poly(vinylidene fluoride), respectively, shows the polymers from 1,1-disubstituted ethylenes have lower T_g and T_m values than do those from the monosubstituted ethylenes. One might have predicted the opposite result because of the greater polarity and molecular symmetry of the polymers from 1,1-disubstituted ethylenes. Apparently, the presence of two side groups instead of one separates polymer chains from each other and results in more flexible polymer chains. Thus, the effects of substituents on T_g and T_m depend on their number and identity.

The rigidity of polymer chains is especially high when there are cyclic structures in the main polymer chains. Polymers such as cellulose have high T_g and T_m values. On the other hand, the highly flexible polysiloxane chain (a consequence of the large size of Si) results in very low values of T_g and T_m .

Although T_g and T_m depend similarly on molecular structure, the variations in the two transition temperature do not always quantitative parallel each other. Table 1-3 shows the various polymers listed in order of increasing T_g values. The T_m values are seen to generally increase in the same order, but there are many polymers whose T_m values do not follow in the same exact order. Molecular symmetry, chain rigidity, and secondary forces do not affect T_g and T_m in the same quantitative manner. Thus polyethylene and polyoxymethylene have low T_g values because of their highly flexible chains; however, their simple and regular structures yield tightly packed crystal structures with high T_m values. An empirical consideration of ratio T_g/T_m (Kelvin temperatures) for various polymers aids this discussion. The T_g/T_m ratio is approximately 1/2 for symmetric polymers [e.g., poly(vinylidene chloride)], but the ratio is closer to 3/4 for unsymmetric polymers (e.g., poly(vinyl chloride)). This result indicates that T_m is more dependent on molecular symmetry, while T_g is more dependent on secondary forces and chain flexibility.

It should be evident that some of the factors that decrease the crystallization tendency of a polymer also lead to increased values of T_m (and also T_g). The reason for this is that the extent of crystallinity developed in a polymer is both kinetically and thermodynamically controlled, while the melting temperature is only thermodynamically controlled. Polymers with rigid chains are difficult or slow to crystallize, but the portion that does crystallize will have a high melting temperature. (The extent of crystallinity can be significantly increased in such polymers by mechanical stretching to align and crystallize the polymer chains.) Thus compare the differences between polyethylene and poly(hexamethylene adipamide). Polyethylene tends to crystallize easier and faster than the polyamide because of its simple and highly regular structure and is usually obtained with greater degrees of crystallinity. On the other hand, the T_m of the polyamide is much higher (by $\sim 130^\circ\text{C}$) than that of polyethylene because of the much greater secondary forces.

1-6 APPLICATIONS OF POLYMERS

1-6a Mechanical Properties

Many polymer properties such as solvent, chemical, and electrical resistance and gas permeability are important in determining the use of a specific polymer in a specific application. However, the prime consideration in determining the general utility of a polymer is its

mechanical behavior, that is, the mechanical behavior of a polymer as one applies to it where it ruptures (pulls apart) elongation (strain). The stress is in newtons per square meter (N m⁻²) or megapascals (MPa) where the length of the polymer sample is the length of the polymer sample. The strain can also be in N cm⁻² is the SI unit for stress. The conversion factor for stress is 1 MPa = 10⁶ N m⁻². The conversion factor for strain is 1 cm = 10⁻² m. The conversion factor for stress is 1 MPa = 10⁶ N m⁻². The conversion factor for strain is 1 cm = 10⁻² m. The conversion factor for stress is 1 MPa = 10⁶ N m⁻². The conversion factor for strain is 1 cm = 10⁻² m.

Several stress-strain plots show the stress-strain behavior of a

1. **Modulus.** The resistance to deformation is $\Delta L/L$.

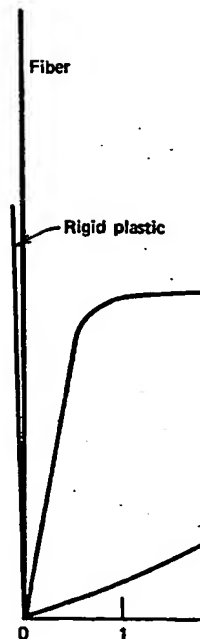


Fig. 1-10 Stress-strain plot

used chain rigidity, and high T_g are typical of polymers with substituents as in poly(methyl methacrylate) as in polystyrene. The T_m values would also be high. The effects of comparison of polypropylene, poly(vinylidene fluoride), poly(vinylidene chloride), and others from 1,1-disubstituted ethylenes to monosubstituted ethylenes. One might expect polarity and molecular symmetry of the polymer, the presence of two side groups and results in more flexible polymer chains. The effects depend on their number and identity. When there are cyclic structures in the polymer, high T_g and T_m values. On the other hand, the presence of the large size of Si results in

structure, the variations in the two levels are small. Table 1-3 shows the results. The T_m values are seen to generally follow the T_g values whose T_m values do not follow in the same way. Secondary forces do not affect T_g . Polyethylene and polyoxymethylene have low T_g values, their simple and regular structures. An empirical consideration of the data supports this discussion. The T_g/T_m ratio for poly(vinylidene chloride) is 0.5, but the ratio is 0.2 for poly(vinyl chloride). This result indicates that T_g is more dependent on secondary

ease the crystallization tendency of a polymer (T_g). The reason for this is that the crystallization is kinetically and thermodynamically controlled. Polymers with a tendency to crystallize will have a T_g that is significantly increased in such cases (e.g., the polymer chains). Thus, poly(methyl methacrylate) and poly(ethylene terephthalate) (PET) are examples. Poly(ethylene terephthalate) (PET) is a polyamide because of its simple and greater degrees of crystallinity. On the other hand, poly(ethylene terephthalate) (PET) is a polyamide (by $\sim 130^\circ\text{C}$) than that of polyethy-

electrical resistance and gas permeability of a polymer in a specific application. The general utility of a polymer is its

mechanical behavior, that is, its deformation and flow characteristics under stress. The mechanical behavior of a polymer can be characterized by its stress-strain properties [Billmeyer, 1984; Nielsen and Landel, 1994]. This often involves observing the behavior of a polymer as one applies tension stress to it in order to elongate (strain) it to the point where it ruptures (pulls apart). The results are usually shown as a plot of the stress versus elongation (strain). The stress is usually expressed in newtons per square centimeter (N cm^{-2}) or megapascals (MPa) where $1 \text{ MPa} = 100 \text{ N cm}^{-2}$. The strain is the fractional increase in the length of the polymer sample (i.e., $\Delta L/L$, where L is the original, unstretched sample length). The strain can also be expressed as the percent elongation, $\Delta L/L \times 100\%$. Although N cm^{-2} is the SI unit for stress, psi (pounds per square inch) is found extensively in the literature. The conversion factor is $1 \text{ N cm}^{-2} = 1.450 \text{ psi}$. SI units will be used throughout this text with other commonly used units also indicated.

Several stress-strain plots are shown in Fig. 1-10. Four important quantities characterize the stress-strain behavior of a polymer:

1. **Modulus.** The resistance to deformation as measured by the initial stress divided by $\Delta L/L$.

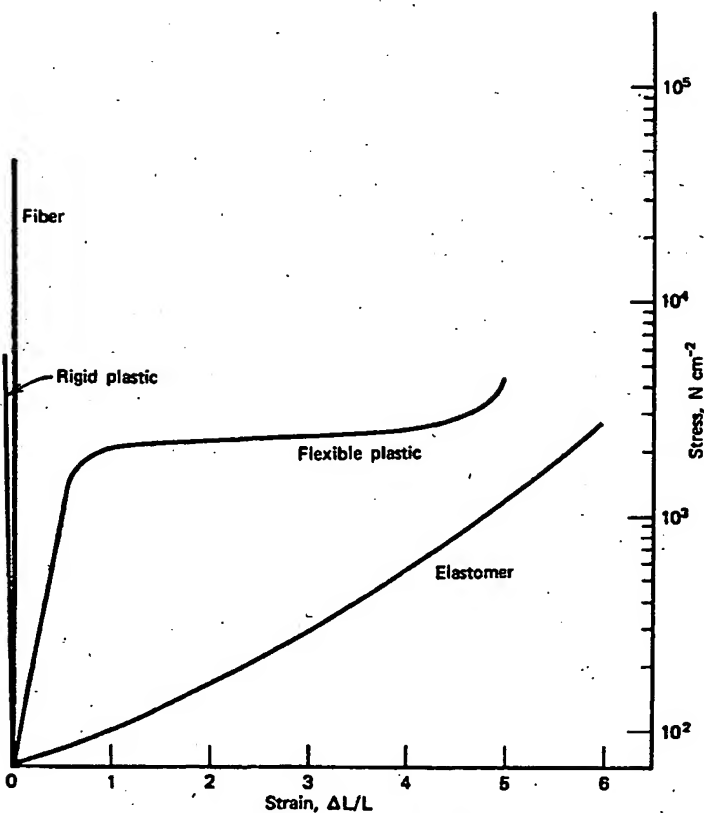


Fig. 1-10 Stress-strain plots for a typical elastomer, flexible plastic, rigid plastic, and fiber.

2. *Ultimate Strength or Tensile Strength.* The stress required to rupture the sample.
3. *Ultimate Elongation.* The extent of elongation at the point where the sample ruptures.
4. *Elastic Elongation.* The elasticity as measured by the extent of reversible elongation.

Polymers vary widely in their mechanical behavior depending on the degree of crystallinity, degree of crosslinking, and the values of T_g and T_m . High strength and low extensibility are obtained in polymers by having various combinations of high degrees of crystallinity or crosslinking or rigid chains (characterized by high T_g). High extensibility and low strength in polymers are synonymous with low degrees of crystallinity and crosslinking and low T_g values. The temperature limits of utility of a polymer are governed by its T_g and/or T_m . Strength is lost at or near T_g for an amorphous polymer and at or near T_m for a crystalline polymer.

An almost infinite variety of polymeric materials can be produced. The polymer scientist must have an awareness of the properties desired in the final polymer in order to make a decision about the polymer to be synthesized. Different polymers are synthesized to yield various mechanical behaviors by the appropriate combinations of crystallinity, crosslinking, T_g , and T_m . Depending on the particular combination, a specific polymer will be used as a *fiber*, *flexible plastic*, *rigid plastic*, or *elastomer* (rubber). Commonly encountered articles that typify these uses of polymers are clothing and rope (fiber), packaging films and seat covers (flexible plastic), eyeglass lenses and housings for appliances (rigid plastic), and rubber bands and tires (elastomer). Table 1-4 shows the uses of many of the common polymers. Some polymers are used in more than one category because certain mechanical properties can be manipulated by appropriate chemical or physical means, such as by altering the crystallinity or adding plasticizers (Sec. 3-14c-1) or copolymerization (Sec. 3-14b, Chap. 6). Some polymers are used as both plastics and fibers, other as both elastomers and plastics.

TABLE 1-4 Use of Polymers

Elastomers	Plastics	Fibers
Polyisoprene	Polyethylene	
Polyisobutylene	Polytetrafluoroethylene	
	Poly(methyl methacrylate)	
	Phenol-formaldehyde	
	Urea-formaldehyde	
	Melamine-formaldehyde	
	Polystyrene	
	Poly(vinyl chloride)	
	Polyurethane	
	Polysiloxane	
		Polyamide
		Polyester
		Cellulosics
		Polypropene
		Polyacrylonitrile

1-6b Elastomers, Fibers,

The differences between fibers, in Fig. 1-10. The modulus of a fiber and ultimate elongation are the are the group of polymers that (1000%) at relatively low stress completely) amorphous with a as to obtain high polymer chain deformation is rapidly and com mer should be very low (<100 ing elongation; otherwise, it w strains. Most elastomers obtain reinforcing inorganic fillers (e. amount of crystallization durin acts as an additional strength below or not significantly above tals melt and deformation be i rubber) is a typical elastome (-73°C), and has a low T_m (2 that is initially less than 70 N at 400% elongation and about over the whole elongation rang crosslinking and the resulting s considerable range depending c automobile tire requires much mer used for producing rubber less tendency to elongate than verts the polymer to a rigid pl

Fibers are polymers that h low elongations (<10–50%) : strengths (>35,000 N cm⁻²). chains with strong secondary f used to impart very high crysta must be above 200°C so that i tures encountered in cleaning s higher than 300°C—otherwise The polymer should be solubl dry-cleaning solvents. The gla too high a T_g interferes with low a T_g would not allow cre typical fiber. It is stretched to ondary forces due to hydroge cm⁻²), very high modulus (50 have optimal values of 265 an exception to the generalizati polypropene used as a fiber t stretched to yield a highly ori fiber (see Sec. 8-11d).]

quired to rupture the sample.
t the point where the sample

e extent of reversible elongation.

ending on the degree of crystal-
gh strength and low extensibility
f high degrees of crystallinity or
extensibility and low strength in
ty and crosslinking and low T_g
governed by its T_g and/or T_m .
d at or near T_m for a crystalline

produced. The polymer scientist
nal polymer in order to make a
olymers are synthesized to yield
ons of crystallinity, crosslinking,
ecific polymer will be used as a
Commonly encountered articles
r), packaging films and seat cov-
iances (rigid plastic); and rubber
many of the common polymers.
se certain mechanical properties
means, such as by altering the
copolymerization (Sec. 3-14b,
fibers, other as both elastomers

Fibers

—Polyamide—
—Polyester—
—Cellulosics—
—Polypropene—

Polyacrylonitrile

1-6b Elastomers, Fibers, and Plastics

The differences between fibers, plastics, and elastomers can be seen in the stress-strain plots in Fig. 1-10. The modulus of a polymer is the initial slope of such a plot; the tensile strength and ultimate elongation are the highest stress and elongation values, respectively. Elastomers are the group of polymers that can easily undergo very large, reversible elongations (≤ 500 – 1000%) at relatively low stresses. This requires that the polymer be completely (or almost completely) amorphous with a low glass transition temperature and low secondary forces so as to obtain high polymer chain mobility. Some degree of crosslinking is needed so that the deformation is rapidly and completely reversible (elastic). The initial modulus of an elastomer should be very low ($< 100 \text{ N cm}^{-2}$), but this should increase fairly rapidly with increasing elongation; otherwise, it would have no overall strength and resistance to rupture at low strains. Most elastomers obtain the needed strength via crosslinking and the incorporation of reinforcing inorganic fillers (e.g., carbon black, silica). Some elastomers undergo a small amount of crystallization during elongation, especially at very high elongations, and this acts as an additional strengthening mechanism. The T_m of the crystalline regions must be below or not significantly above the use temperature of the elastomer in order that the crystals melt and deformation be reversible when the stress is removed. Polyisoprene (natural rubber) is a typical elastomer—it is amorphous, is easily crosslinked, has a low T_g (-73°C), and has a low T_m (28°C). Crosslinked (moderately) polyisoprene has a modulus that is initially less than 70 N cm^{-2} ; however, its strength increases to about 1500 N cm^{-2} at 400% elongation and about 2000 N cm^{-2} at 500% elongation. Its elongation is reversible over the whole elongation range, that is, up to just prior to the rupture point. The extent of crosslinking and the resulting strength and elongation characteristics of an elastomer cover a considerable range depending on the specific end use. The use of an elastomer to produce an automobile tire requires much more crosslinking and reinforcing fillers than does the elastomer used for producing rubber bands. The former application requires a stronger rubber with less tendency to elongate than the latter application. Extensive crosslinking of a rubber converts the polymer to a rigid plastic.

Fibers are polymers that have very high resistance to deformation—they undergo only low elongations (< 10 – 50%) and have very high moduli ($> 35,000 \text{ N cm}^{-2}$) and tensile strengths ($> 35,000 \text{ N cm}^{-2}$). A polymer must be very highly crystalline and contain polar chains with strong secondary forces in order to be useful as a fiber. Mechanical stretching is used to impart very high crystallinity to a fiber. The crystalline melting temperature of a fiber must be above 200°C so that it will maintain its physical integrity during the use temperatures encountered in cleaning and ironing. However, T_m should not be excessively high—not higher than 300°C —otherwise, fabrication of the fiber by melt spinning may not be possible. The polymer should be soluble in solvents used for solution spinning of the fiber but not in dry-cleaning solvents. The glass transition temperature should have an intermediate value; too high a T_g interferes with the stretching operation as well as with ironing, while too low a T_g would not allow crease retention in fabrics. Poly(hexamethylene adipamide) is a typical fiber. It is stretched to high crystallinity, and its amide groups yield very strong secondary forces due to hydrogen bonding; the result is very high tensile strength ($70,000 \text{ N cm}^{-2}$), very high modulus ($500,000 \text{ N cm}^{-2}$), and low elongation ($< 20\%$). The T_m and T_g have optimal values of 265 and 50°C , respectively. [The use of polypropene as a fiber is an exception to the generalization that polar polymers are required for fiber applications. The polypropene used as a fiber has a highly stereoregular structure and can be mechanically stretched to yield a highly oriented polymer with the strength characteristics required of a fiber (see Sec. 8-11d).]


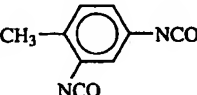
Plastics represent a large group of polymers that have a wide range of mechanical behaviors in between those of the elastomers and fibers. There are two types of plastics—flexible plastics and rigid plastics. The flexible plastics possess moderate to high degrees of crystallinity and a wide range of T_m and T_g values. They have moderate to high moduli (15,000–350,000 N cm⁻²), tensile strengths (1500–7000 N cm⁻²), and ultimate elongations (20–800%). The more typical members of this subgroup have moduli and tensile strengths in the low ends of the indicated ranges with elongations in the high end. Thus polyethylene is a typical flexible plastic with a tensile strength of 2500 N cm⁻², a modulus of 20,000 N cm⁻², and an ultimate elongation of 500%. Other flexible plastics include polypropene and poly(hexamethylene adipamide). Poly(hexamethylene adipamide) is used as both a fiber and a flexible plastic. It is a plastic when it has moderate crystallinity, while stretching converts it into a fiber. Many flexible plastics undergo large ultimate elongations—some as large as those of elastomers. However, they differ from elastomers in that only a small portion (approximately <20%) of the ultimate elongation is reversible. The elongation of a plastic past the reversible region results in its permanent deformation, that is, the plastic will retain its elongated shape when the stress is removed.

The rigid plastics are quite different from the flexible plastics. The rigid plastics are characterized by high rigidity and high resistance to deformation. They have high moduli (70,000–350,000 N cm⁻²) and moderate to high tensile strengths (3000–8500 N cm⁻²), but more significantly, they undergo very small elongations (<0.5–3%) before rupturing. The polymers in this category are amorphous polymers with very rigid chains. The high chain rigidity is achieved in some cases by extensive crosslinking, for example, phenol-formaldehyde, urea-formaldehyde, and melamine-formaldehyde polymers. In other polymers the high rigidity is due to bulky side groups on the polymer chains resulting in high T_g values, for example, polystyrene ($T_g = 100^\circ\text{C}$) and poly(methyl methacrylate) ($T_g = 105^\circ\text{C}$).

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PROBLEMS

- 1-1 Show by equations the o from
- $\text{CH}_2=\text{CH}-\text{CO}_2\text{H}$
 - 
 - $\text{H}_2\text{N}-(\text{CH}_2)_5-\text{NH}_2$
 - $\text{HO}-(\text{CH}_2)_5-\text{CO}_2\text{H}$
 - 
 - $\text{CH}_2=\text{CH}-\text{F}$
- 1-2 What is the structure of any other monomer(s) t polymer?
- 1-3 Classify the polymers Classify the polymeriz polymerizations.
- 1-4 How would you experim monomer X was proces
- 1-5 Name each of the poly names where applicable trade names.
- 1-6 Name each of the follo
- $-(\text{OCH}_2)_n-$
 $\text{CH}_2\text{COOCH}_3$



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con-cu-plis-ence \k'an-'kyu-pə-sən(t)s, kən-'n [ME, fr. MF, fr. LL *concupiscere*, fr. L. *concupiscere*; *concupiscens*; pp. of *concupiscere* 'to desire'; ardently, fr. *com-* + *cupere* 'to desire'—more at COVER] (14c) : strong desire; esp. : sexual desire ~ *con-cu-plis-ent* \-sən(t) *adj*
con-cu-plis-ible \-'kyu-pə-sə-bəl/ *adj* [ME, fr. MF or LL; MF, fr. LL *concupiscibilis*, fr. L. *concupiscere*] (14c) : LUSTFUL; DESIROUS ~
con-cur \k'an-'kər, kən-'v/ *con-curred*; *con-cur-ring* [ME *concurrere*, fr. L. *concurrere*; fr. *com-* + *currere* 'to run'—more at CAR] (15c) 1 : to act together to a common end or single effect; 2 a : APPROVE (~in a statement) b : to express agreement (~ with an opinion) 3 obs : to come together : MEET 4 : to happen together : COINCIDE *syn* see IAGREE
con-cur-ence \-'kər-ən(t)s, -'kər-rən(t)s/ *n* (15c) 1 a : agreement or union in action : COOPERATION b (1) : agreement in opinion or design (2) : CONSENT; 2 : a coming together : CONJUNCTION 3 : a coincidence of equal powers in law
con-cu-rrent \-'kər-ən(t), -'kər-rən(t) *adj* [ME, fr. MF & L; MF, fr. L. *concurrent*; *concurrans* pp. of *concurrere*] (14c) 1 : operating or occurring at the same time 2 a : CONVERGENT; *specific* : meeting or intersecting in a point b : running parallel 3 : acting in conjunction 4 : exercised over the same matter or area by two different authorities (~ jurisdiction) — *con-cu-rrent* *n* — *con-cu-rrent-ly* *adv*
con-current resolution *n* (1802) : a resolution passed by both houses of a legislative body that lacks the force of law
con-cuss \kən-'kəs/ *v* [L. *concussus*, pp.] (1597) : to affect with or as if with concussion
con-cus-sion \kən-'kəsh-ən/ *n* [MF or L; MF, fr. L. *concussio*; *con-* + *quassare* 'to shake'] (15c) 1 : AGITATION, SHAKING 2 a : a hard blow or collision b : a stunning, damaging, or shattering effect from a hard blow; esp. : a jarring injury of the brain resulting in disturbance of cerebral function — *con-cus-sive* \-'kəs-iv/ *adj*
con-demn \kən-'dem/ *v* [ME *condemnen*, fr. MF *condemner*, fr. L. *condemnare*, fr. *com-* + *damnare* to condemn — more at DAMN] (14c) 1 : to declare to be reprehensible, wrong, or evil; usu. after weighing evidence and without reservation 2 a : to pronounce guilty : CONVICT b : SENTENCE, DOOM 3 : to adjudge unfit for use or consumption 4 : to declare convertible to public use under the right of eminent domain *syn* see CRITICIZE — *con-dem-nable* \-'dem-(n)ə-bəl/ *adj* — *con-dem-na-to-ry* \-'nə,-tōr-ē, -tōr-/ *adj* — *con-dem-ner* \-'dem-ər/ or *con-dem-nor* \kən-'dem-/ *n* — *con-dem-nō-sal* \-'dem-nō-səl, kən-'n/ *adj*
con-dem-na-tion \kən-'dem-nā-shən, -dem-/ *n* (14c) 1 : CENSURE, BLAME 2 : the act of judicially condemning 3 : the state of being condemned 4 : a reason for condemning
con-dense \k'an-'dən,-sāt, -den; kən-'den-/ *n* (ca. 1885) : a product of condensation; esp. : a liquid obtained by condensation of a gas or vapor (steam ~)
con-densa-tion \k'an-'den,-sā-shən, -dən-/ *n* (1603) 1 : the act or process of condensing; as a : a chemical reaction involving union between molecules often with elimination of a simple molecule (as water) to form a new more complex compound of often greater molecular weight b : a reduction to a denser form (as from steam to water) c : compression of a written or spoken work into more concise form 2 : the quality or state of being condensed 3 : a product of condensing; esp. : an abridgment of a literary work — *con-densa-tional* \-shənəl, -shan-/ *adj*
con-dense \kən-'den(t)s/ *v* *b* *con-densed*; *con-dens-ing* [ME *condensere*, fr. MF *condenser*, fr. L. *condensare*, fr. *com-* + *densare* to make dense, fr. *densus* dense] *v* (15c) : to make denser or more compact; esp. : to subject to condensation ~ *vi* : to undergo condensation *syn* see CONTRACT — *con-dens-able* *also* *con-dens-ible* \-'den(t)-sə-bəl/ *adj*
con-densed *adj* (15c) : reduced to a more compact form; esp. : having a face that is narrower than that of a typeface not so characterized
condensed milk *n* (1863) : evaporated milk with sugar added
con-denser \kən-'den(t)-sər/ *n* (1686) 1 : one that condenses; as a : a lens or mirror used to concentrate light on an object b : an apparatus in which gas or vapor is condensed 2 : CAPACITOR
con-descend \k'an-'di-'send/ *v* [ME *condescenden*, fr. MF *condescendere*, fr. LL *condescendere*, fr. L. *com-* + *descendere* to descend] (14c) 1 a : to descend to a less formal or dignified level : UNBEND b : to waive the privileges of rank 2 : to assume an air of superiority
con-descen-dence \-'sen-dən(t)s/ *n* (1638) : CONDESCENSION
con-descend-ing *adj* (1707) : showing or characterized by condescension : PATRONIZING — *con-descend-ing-ly* \-'sen-din-/ *adv*
con-descen-sion \k'an-'di-'sen-chen/ *n* [LL *condescension*; *condescensio*, fr. *condescensus*, pp. of *condescendere*] (1647) 1 : voluntary descent from one's rank or dignity in relations with an inferior 2 : patronizing attitude or behavior
con-dign \kən-'dīn; kən-'v/ *adj* [ME *condigne*, fr. MF, fr. L. *condignus* very worthy, fr. *com-* + *dignus* worthy — more at DECENT] (15c) : DESERVED, APPROPRIATE (~ punishment) — *con-dign-ly* *adv*
con-di-ment \k'an-'di-mənt/ *n* [ME, fr. MF, fr. L. *condimentum*, fr. *condire* to pickle; fr. *condere* to build, store up, fr. *com-* + *-dere* to put — more at DO] (15c) : something used to enhance the flavor of food; esp. : a pungent seasoning — *con-di-men-tal* \k'an-'di-mənt-/ *adj*
con-dition \kən-'dīsh-ən/ *n* [ME *condicion*, fr. MF, fr. L. *condicio*; *condicio* terms of agreement, condition, fr. *condicere* to agree, fr. *com-* + *dicere* to say, determine — more at DICTION] (14c) 1 a : a premise upon which the fulfillment of an agreement depends : STIPULATION b obs : COVENANT c : a provision making the effect of a legal instrument contingent upon an uncertain event; also : the event itself 2 : something essential to the appearance or occurrence of something else : PREREQUISITE; as a : an environmental requirement (available oxygen is an essential ~ for animal life) b : the subordinate clause of a conditional sentence 3 a : a restricting or modifying factor : QUALIFICATION b : an unsatisfactory academic grade that may be raised by

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Revised by
Richard J. Lewis, Sr.



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bleach. To whiten a textile or paper by chemical action. Also the agent itself. Bleaching agents include hydrogen peroxide (the most common), sodium hypochlorite, sodium peroxide, sodium chlorite, calcium hypochlorite, hypochlorous acid, and many organic chlorine derivatives. Chlorinated lime is a bleaching powder used on an industrial scale. Household bleaching powders are sodium perborate and dichlorodimethylhydantoin.

Hazard: See calcium hypochlorite; lime, chlorinated. Some bleaching agents are toxic and strong oxidizing agents.

bleaching assistant. A material added to bleaching baths to secure more rapid and complete penetration of the bleach or improved regulation of the bleaching action, e.g., compounds of sulfonated oils and solvents, soluble pine oils, fatty alcohol salts, sodium silicate, sodium phosphate, magnesium sulfate, and borax.

bleaching, fluorescent. The use of colorless fluorescent organic compounds to produce a whitening effect on textiles.

bleaching powder. See bleach; calcium hypochlorite.

bleach liquor. A solution of either sodium or calcium hypochlorite and water.

bleed. (1) When a dye runs. (2) To release pressure gradually, as via a valve.

blend. A uniform combination of two or more materials either of which could be used alone for the same purpose as the blend. For example, a fabric may be a blend of wool and nylon, either of which is itself usable as fabric. Instances of materials that are often blended are:

plastics (polyblends)	grains
whiskeys	coffees
fabrics	paints
colors	tobaccos
metal powders	solvents
fertilizers	

See mixture; mixing; kneading.

bleomycin. A glycopeptide antibiotic produced by *Streptomyces verticillus*; it functions as an antineoplastic and diagnostic agent. The molecule is exceedingly complex, but synthesis was achieved in 1982. It is a colorless to yellowish powder, soluble in water and methanol but insoluble in acetone and ether. It induces rupture of DNA strands.

blinding. (blister copper).

Properties: Copper (96–99% purity) produced by the reduction and smelting of copper ores. It has a

blistered appearance, probably caused by gas pockets. It is usually further refined electrolytically.

blister gas. See dibromodiethyl sulfide.

blister packaging. A type of packaging used widely in the food and pharmaceutical industries, consisting of a hollow cavity of various shapes and capacities in which the material is enclosed. Polyester and polyethylene resins are often used.

block. (1) Undesirable cohesion of films or layers of plastic.

See antiblock agent.

(2) A type of polymer.

See block polymer.

block copolymer. Polymer containing long stretches of two or more monomeric units linked together by chemical valences in one single chain. See block polymer.

block polymer. A high polymer whose molecule is made up of alternating sections of one chemical composition separated by sections of a different chemical nature or by a coupling group of low molecular weight. An example is blocks of polyvinyl chloride interspersed with blocks of polyvinyl acetate. Such polymer combinations are made synthetically. They depend on the presence of an active site on the polymer chain that initiates the necessary reactions.

See graft polymer; stereoblock polymer.



blood. A complex, liquid tissue of d 1.056 and pH 7.35–7.45. It is comprised of erythrocytes (red cells), leucocytes (white cells), platelets, plasma, proteins, and serum. The plasma fraction (55–70%) is whole blood from which the red and white cells and the platelets have been removed by centrifuging. Hemoglobin is a protein found in the erythrocytes. It contains the essential iron atom and functions as the transport agent for oxygen from the lungs (arterial blood) and of carbon dioxide to the lungs from the heart (venous blood). Experimental work has been reported on the effectiveness of fluorocarbon compounds in carrying out the essential transport functions of blood, especially of the red cells.

Use: Plasma is used to restore liquid volume and thus osmotic pressure in the body where blood loss has been extensive. Animal blood is used as a component of adhesive mixtures. In dried or powder